

EASYARC® 309L

TYPICAL APPLICATIONS

It is for all position welding of 22%Cr-12%Ni austenitic stainless steel ASTM 309, 309L or equivalent steels.

It is for dissimilar joints welding between CrNi or CrNiMo stainless steel to mild steel or low alloyed steel.

It is for build-up welding on mild steel or low alloyed steel.

TOP FEATURES

- Rutile-Basic stainless steel electrode
- Weldable on AC and DCEP
- Excellent weldability, easy slag release
- Low susceptibility to hot cracking
- High resistance to intergranular corrosion

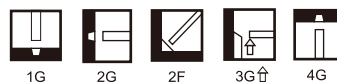
APPROVALS

- ABS

CONFORMANCE

- AWS A5.4/ASME SFA5.4: E309L-17
- GB 983: E309L-17

WELDING POSITIONS



REDRYING

For electrodes that have had a short or mild exposure to the atmosphere then redrying at 300 °C for 1 hour will be sufficient. For electrodes that have been exposed to longer or more aggressive conditions or for critical work redrying at 300-350 °C for 1-2 hours is recommended. After redrying electrodes should be stored in a hot box.

DIAMETERS / PACKAGING

Diameter x Length(mm x mm)	Inner box(KG)	Outer Carton(KG)
2.5 x 300	4	16
3.2 x 350	5	20
4.0 x 350	5	20
5.0 x 350	5	20

MECHANICAL PROPERTIES

Electrode	Condition	Tensile Strength (MPa)	Elongation (%)
AWS:E309L-17 Required	As-welded	≥520	≥30
GB:E309L-17 Required	As-welded	≥520	≥25
EASYARC® 309L	As-welded	600	41

EASYARC® 309L**CHEMICAL COMPOSITION**

	C%	Cr%	Ni%	Mo%	Mn%	Si%	P%	S%	FN
AWS:E309L-17 Required	≤0.04	22.0-25.0	12.0-14.0	≤0.75	0.5-2.5	≤1.00	≤0.04	≤0.03	--
GB:E309L-17 Required	≤0.04	22.0-25.0	12.0-14.0	≤0.75	0.5-2.5	≤0.90	≤0.04	≤0.03	--
EASYARC® 309L	0.020	24.74	12.29	0.148	0.74	0.84	0.020	0.006	13-19

TYPICAL OPERATING PROCEDURES

Diameter x Length (mm x mm)	Welding Position	2.5 x 300	3.2 x 350	4.0 x 350	5.0 x 350
Current [A]	1G,2G,2F	50-85	80-120	100-150	140-180
	3G up,4G	45-80	70-110	90-140	--

Customer Assistance Policy

The business of The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for advice or information about their use of our products. We respond to our customers based on the best information in our possession at that time. Lincoln Electric is not in a position to warrant or guarantee such advice, and assumes no liability, with respect to such information or advice. We expressly disclaim any warranty of any kind, including any warranty of fitness for any customers particular purpose, with respect to such information or advice. As a matter of practical consideration, we also cannot assume any responsibility for updating or correcting any such information or advice once it has not been given, nor does the provision of information or advice create, expand or alter any warranty with respect to the sale of our products.

Lincoln Electric is a responsive manufacturer, but the selection and use of specific products sold by Lincoln Electric is solely within the control of, and remains the sole responsibility of the customer. Many variables beyond the control of Lincoln Electric affect the results obtained in applying these types of fabrication methods and service requirements.

Subject to change - This information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.com.cn for any updated information.

Authorized Distributor:**THE NANJING LINCOLN ELECTRIC CO., LTD.**

No.18 Baoxiang Road,Bingjiang Economic Development Zone,Jiangning District,Nanjing,Jiangsu,China 211100

TEL:86-25-8418 8377

FAX:86-25-8641 8809

www.lincolnelectric.com