



E309L-16



DESCRIPTION: Weldcote Metals E309L-16 gives a weld deposit similar to E309-16, with reduced carbon levels (.04% maximum) that offer increased resistance to intergranular corrosion. Type E309L-16 is ideal for joining stainless steels to themselves or to carbon or low alloy steels. E309L-16 is preferred to E309-16 for cladding over carbon or low alloy steels, as well as dissimilar joints, which undergo heat treatment.

APPROVALS: Manufactured under Quality System approved by ASME, IS09001. Meets AWS 5.4 Class E309L-16.

CHEMICAL COMPOSITION

Carbon	.035
Manganese	1.58
Silicon	.53
Chromium	23.45
Nickel	12.6
Sulfur	.021
Phosphorus	.024
Iron	Balance

MECHANICAL PROPERTIES

Tensile Strength	
88,500 PSI	555 MPA
Yield Strength	
59,000 PSI	410 MPA
Elongation	36%

WELDING PARAMETERS

Direct Current
Electrode + Ve

AMPERAGES:

3/32"	65-75
1/8"	90-105
5/32"	120-135
3/16"	135-155

(For vertical welding amperages are to be reduced by 10 to 15 amps)

Weldcote Metals believes this data to be accurate and to reflect qualified expert opinion regarding current research. However, Weldcote Metals can not make any expressed or implied warranty as to this information.