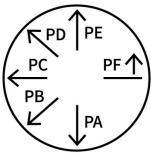


S-309L.17

Classification

- AWS** A5.4/ASME SFA-5.4 E309L-17
- JIS** Z 3221 ES309L-17
- EN** ISO 3581- A E 23 12 L R

Welding Positions



Features

- Good resistance to heat and corrosion
- Good crack resistance
- Easy to remove slag
- High moisture resistance (17 type)

Polarity

AC or DC+

Application Areas

- Welding of dissimilar steels
- Buffer layer for bulid-up

Redrying Conditions

350°C (662°F) X 1hr

Approvals

ABS
✓

Typical Chemical Composition of All-Weld Metal (wt%)

C	Si	Mn	P	S	Cu	Ni	Cr	Mo
0.03	0.63	1.1	0.024	0.015	0.03	12.9	23.9	0.04

Typical Mechanical Properties of All-Weld Metal

Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft·lbs)
570(83)	41	-20(0) -60(-75)	48(35) 40(30)

SAW

GMAW

GTAW

FCAW

Metal-cored Wire

SAW Wire

SAW Flux

Diameter / Welding Parameters / Packaging

Diameter mm(in)	Length mm(in)	F & HF	V-up, OH	Packaging
2.0 (5/64)	300 (12)	25~55	20~50	PVC - Packet 2.5kg(5.5lbs), Carton 10kg (22lbs)
2.6 (3/32)	300 (12)	50~85	45~80	
3.2 (1/8)	350 (14)	70~115	65~110	
4.0 (5/32)	350 (14)	95~145	85~135	
5.0 (3/16)	350 (14)	135~180	-	

SMAW

GMAW

GTAW

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Metal-cored Wire

SAW Wire

SAW Flux