

Covered electrode for dissimilar metals

Classification: ASME / AWS A5.4 E309L-16

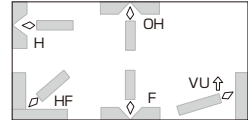
Features:

- Suitable for dissimilar-metal joint and underlaying on ferritic steels in stainless steel weld metal overlaying
- Lower carbon content than **NC-39**

Redrying Conditions: 150~200°Cx0.5~1h

Identification color: 1st Yellow green, 2nd Blue white

Welding Positions:



Chemical composition of all-weld metal (%) as per AWS

	C	Si	Mn	P	S	Ni	Cr
Example	0.030	0.60	1.50	0.020	0.005	12.50	23.13
Guaranty	≤0.04	≤0.90	0.5~2.5	≤0.04	≤0.03	12.0~14.0	22.0~25.0

Mechanical properties of all-weld metal as per AWS

	0.2%OS (MPa)	TS (MPa)	EI (%)	IV (J)
Example	410	560	42	0°C: 67
Guaranty	-	≥520	≥30	-

Recommended welding parameters

	2.0mm	2.6mm	3.2mm	4.0mm	5.0mm
Dia.	2.0mm	2.6mm	3.2mm	4.0mm	5.0mm
F, HF, H	25~55A	50~85A	70~115A	95~145A	135~180A
VU, OH	20~50A	45~80A	65~110A	85~135A	-

Polarity

Example	AC
Guaranty	AC, DC-EP

Approvals

LR	DNV	BV	NK	Others
SS/CMn(Chem.)	309L	UP(E309L-16)	KD309L	TÜV

Packages

Dia. (mm)	Length (mm)	Weight per pack (kg)	Weight per carton (kg)	Weight per piece (g)
2.6	300	2	20	19
3.2	350	5	20	34
4.0	350	5	20	55
5.0	350	5	20	85