

ESAB 309LC

An extra low carbon, basic 23/12 type stainless steel electrode



Classification AWS A 5.4: E 309L-15
 IS 5206: E 23.12 L B 20
 DIN 8556: E 23 12 L B 20

DESCRIPTION

ESAB 309LC is an extra low carbon all position basic coated electrode giving austenitic weld deposit of 23 Cr-13 Ni type suitable for welding heat resistant Cr-Ni alloyed steels for working temperatures upto 1000°C, where sulphurous attack does not occur. ESAB 309LC possess excellent weldability in all positions with a fine, stable, smooth arc and a slag system that allows good wetting and an easily removable slag. The final weldbead is shiny, finely rippled and smooth. Welds are of radiographic quality.

WELDING CURRENT: DC+

TYPICAL APPLICATIONS

It is recommended for applications requiring superior corrosion resistance, high strength and oxidation resistance upto 1000°C where the sulphurous attack does not occur. It is also eminently suitable for welding stainless steel to unalloyed steel and also for welding of 304L and 309L clad steels. It is also used as buffer in cladding.

TYPICAL ALL WELDMETAL PROPERTIES

Chemical Composition (%)				Mechanical Properties	
C	0.028	Ni	13.0	UTS	580 N/mm ²
Mn	1.60	Si	0.40	YS	450 N/mm ²
Cr	23.0	S	0.015	EL (L=4d)	35%
P	0.020				

CURRENT RANGE & PACKING DATA

Size (mm)	Length (mm)	Current Range (Amps)	No. of Electrodes in a	
			Carton	Cardboard box
2.50	350	60-90	80	400
3.15	350	85-130	65	325
4.00	350	120-180	40	200
5.00	350	160-240	30	150

PACKING: Electrodes are packed in heat sealed plastic cartons and five of these cartons are shrink wrapped in a cardboard box.