

D&H 309L

CODIFICATION :

AWS	:	SFA 5.4 E309L-16	
IS	:	5206 E23.12L R16	

CHARACTERISTICS AND APPLICATIONS :

D&H 309L is a stainless steel electrode depositing an extra low carbon 24Cr - 12Ni weld metal. The weld metal has excellent mechanical properties and possesses good oxidation and scaling resistance at elevated temperatures. Ideally suited for welding stainless steels, wrought and cast materials of similar composition, welding of 18/8 type stainless steels to carbon steels for buffer layers, for welding clad side of 18/8 clad stainless steels, etc.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element :	C	Mn	Si	Cr	Ni	S	P
Percent :	0.03	1.60	0.50	23.6	12.80	0.020	0.025

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS	Elongation
(MPa)	(L = 4d)%
576	38.0

CURRENT AND PACKING DATA: AC / DC(+)

Size (mm)	:	5x350	4x350	3.15x350	2.5x350
Dia x Length					
Current Range	:	150-180	110-140	80-100	60-80
(Amps)					
Weight/Cartron	:	2.5	2.5	2.5	2.5
(kgs)					

APPROVALS: Adani Infra, BV, BHEL, EIL, L&T Power, NPCIL, NTPC

PRECAUTIONS:

1. Ensure the electrodes are dry. In case of moisture pick-up, redry the electrodes at 250-300°C for one hour.
2. Use short arc and stringer bead.

NOTE: D&H 309L-15 conforming to AWS E309L-15 is also available.