



PRODUCT DATA SHEET

STAINLESS STEEL ELECTRODES

STAINCORD 309L



SUMMARY

- > All positional, rutile type stainless steel electrode
- > Suited to welding stainless steel containing 22 - 25% Cr and 12 -14% Ni
- > Suitable for the dissimilar welding of stainless steel to mild/low alloy steels

IDENTIFICATION

Coating - Grey Tip - Plain Imprint - E309/E309L-16

CLASSIFICATION

- > AS/NZS 4854-B - ES309L-16
- > AWS A5.4 E309L-16

DESCRIPTION AND APPLICATION

Staincord 309L is a rutile coated - all position electrode for welding stainless steel containing 22 - 25% Cr and 12 - 14% Ni. AISI 309 may also be used for welding dissimilar metals, e.g. stainless steels type 18/8 to mild steel. Also used for welding the buffer layer of the 18/8 clad steels.

NOTES ON USAGE

1. Clean up the contaminations on the base metal, groove and pass to pass with stainless steel brush.
2. Maintain short arc length. Moving range should be controlled within 2.5 times of the electrodes diameter when you are welding with weave method.
3. Dry the electrodes at 250–300 °C for 60 minutes before using, then store in a hot box at 100–150 °C during welding process.
4. Use lower current to prevent from cracking and minimize base metal dilution.

OPERATIONAL DATA

ELECTRODE SIZE (MM)	ELECTRODE LENGTH (MM)	WELD CURRENT RANGE * (A)
2.6	300	50 - 90
3.2	350	70 - 130

*Recommended for DC + or AC (minimum 70 OCV).

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

C	Cr	Ni	Mn	Si	P	S
0.3	23.0	13.2	0.98	0.70	0.030	0.010

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

Tensile Strength	600 MPa
Elongation	40%

PACKAGING DATA

ELECTRODE SIZE (MM)	PACKAGING (KG)		PART NO.
	PACKET	CARTON	
2.6	2.5	12.5	SC309L26TT
3.2	2.5	12.5	SC309L32TT

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