

**EASYARC™ 309L****CONFORMANCE**

- AWS A5.4/ASME SFA5.4: E309L-17
- GB 983: E309L-17

**WELDING POSITIONS****APPLICATION**

- It is for all position welding of 22%Cr-12%Ni austenitic stainless steel ASTM 309, 309L or equivalent steels.
- It is for dissimilar joints welding between CrNi or CrNiMo stainless steel to mild steel or low alloyed steel.
- It is for build-up welding on mild steel or low alloyed steel.

**REDRYING**

- For electrodes that have had a short or mild exposure to the atmosphere then re-drying at 300°C for 1 hour will be sufficient. For electrodes that have been exposed to longer or more aggressive conditions or for critical work redrying at 300-350°C for 1-2 hours is recommended. After redrying electrodes should be stored in a hot box.

**FEATURES**

- Rutile-Basic stainless steel electrode
  - Weldable on AC and DCEP
  - Excellent weldability, easy slag release
  - Low susceptibility to hot cracking
  - High resistance to intergranular corrosion
- \* Please contact the local customer service for more package types.

**EASYARC™ 309L****DIAMETERS/PACKAGING**

Diameter × Length (mm × mm)	Inner box	Package - Weight (kg)	Outer Carton
2.5 x 300	4		16
3.2 x 350	5		20
4.0 x 350	5		20
5.0 x 350	5		20

**ALL WELD METAL MECHANICAL PROPERTIES -- TYPICAL**

Electrode	Condition	Tensile Strength (Mpa)	Elongation (%)
AWS E309L-17 Required	As-welded	≥520	≥30
GB E309L-17 Required	As-welded	≥520	≥25
EASYARC™ 309L	As-welded	600	41

**ALL WELD METAL CHEMICAL COMPOSITIONS (Wt-%) -- TYPICAL**

Electrode	C	Cr	Ni	Mo	Mn	Si	P	S	FN
AWS E309L-17 Required	≤0.04	22.0-25.0	12.0-14.0	≤0.75	0.5-2.5	≤1.00	≤0.04	≤0.03	—
GB E309L-17 Required	≤0.04	22.0-25.0	12.0-14.0	≤0.75	0.5-2.5	≤0.90	≤0.04	≤0.03	—
EASYARC™ 309L	0.020	24.74	12.29	0.148	0.74	0.84	0.020	0.006	13-19

**RECOMMENDED WELDING CURRENT (CURRENT POLARITY: DC+ & AC)**

Diameter × Length (mm × mm)	Welding Position	2.5 x 300	3.2 x 350	4.0 x 350	5.0 x 350
Current (A)	1G, 2G, 2F	50-85	80-120	100-150	140-180
	3G up, 4G	45-80	70-110	90-140	—

**Customer Assistance Policy**

The business of The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for advice or information about their use of our products. We respond to our customers based on the best information in our possession at that time. Lincoln Electric is not in a position to warrant or guarantee such advice, and assumes no liability, with respect to such information or advice. We expressly disclaim any warranty of any kind, including any warranty of fitness for any customers particular purpose, with respect to such information or advice. As a matter of practical consideration, we also cannot assume any responsibility for updating or correcting any such information or advice once it has not been given, nor does the provision of information or advice create, expand or alter any warranty with respect to the sale of our products.

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