

❖ Product Description

- I. A medium heavy coated rutile type electrode with weld deposit 25Cr-12Ni
- II. Resistant to chemical corrosion
- III. Suitable for steel containing 22-26%Cr & 11-14% Ni
- IV. For joints between mild steel and stainless steel alloys

❖ Range of Application

- I. For welding 309 grade of stainless steel
- II. For joining clad steel, carbon steel and low alloy steel

❖ Classification

- AWS/SFA 5.9 E309L

❖ % Chemical Composition

Type of Wire		C	Mn	S	Si	P	Cu	Cr	Ni	Mo
E309L	Min	-	1.0	-	0.30	-	-	23.0	12.0	-
	Max	0.03	2.5	0.03	0.65	0.030	0.75	25.0	14.0	0.75

❖ Wire Size & Welding Position

- Diameter in mm- 1.60, 2.00, 2.40, 3.20, 4.00, 5.00.
- Weld Position- All position

❖ Packaging

- 25kg coil with or without support

Special Notes: -

- (1) All the value above mentioned are typical values.
- (2) Usually all chemistry and mechanical properties will depend on actual wire chemistry and arc voltage used for welding.

SHAKUNT ENTERPRISES PRIVATE LIMITED

Corporate Office: - 619/A, EMMAR DIGITAL GREEN, 6th Floor, Sector-61, GURUGRAM (HARYANA)-122102
E-Mail:- info@shakunt.com

Ludhiana Works:- B-XXIX-595/5,Campa Cola Road,Dhandari Kalan Industrial Area-C,Ludhiana (PUNJAB) INDIA

Dharwad Works:- Plot no.577 C & D,Belur Industrial Area,Dharwad-580011 (KARNATAKA) INDIA

Vadodara Works:- 67-A,G.I.D.C,Majusar,Savli,Vadodara-397115 (GUJARAT) INDIA