OK 309L



Acid-rutile coated MMA-electrode giving an overalloyed weld metal. Suitable for welding stainless steel to mild and low alloyed steels. Also suitable for welding of transition layers when surfacing mild steel with stainless steel weld metal.

Specifications	
Classifications	EN ISO 3581-A : E 23 12 L R 3 2 SFA/AWS A5.4 : E309L-16

Welding Current	AC, DC+
Ferrite Content	FN 12 - 22
Alloy Type	Austenitic CrNi
Coating Type	Acid Rutile
Min AC OCV	55

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
ISO			
As Welded	470 MPa	580 MPa	32 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
ISO		
As Welded	20 °C	50 J
As Welded	-10 °C	40 J

Typical Weld Metal Analysis %						
C	**Mn**	**Si**	**Ni**	**Cr**	**N**	**FN WRC-92**
0.03	0.9	0.8	12.4	23.7	0.09	15

Deposition Data					
Diameter	**Current**	**Voltage**	**Efficiency (%)**	**Fusion time per electrode at 90% I max**	**Deposition Rate**
2.5 x 300 mm	45-90 A	28 V	60 %	38 sec	1.1 kg/h
3.2 x 350 mm	65-120 A	29 V	60 %	51 sec	1.6 kg/h
4.0 x 350 mm	85-180 A	31 V	60 %	51 sec	2.5 kg/h