

Limarosta® 309S

TOP FEATURES

- Self releasing slag.
- Excellent side wall wetting, no undercut, mirror like bead appearance.
- High resistance to porosity.

CLASSIFICATION

AWS A5.4 E309L-17
EN ISO 3581-A E 23 12 L R 32

CURRENT TYPE

AC/DC+

WELDING POSITIONS

All position, except vertical down

APPROVALS

LR	DNV	TÜV	DB
+	+	+	+

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Si	Cr	Ni	FN (acc. WRC 1992)
0.02	0.8	1.0	23.0	12.5	10-20

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	0.2% Proof strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)	
					+20°C	-20°C
Required: AWS A5.4		not specified	min. 520	min. 30	not specified	
EN ISO		min. 320	min. 510	min. 25	not specified	
Typical values	AW	440	600	40	55	50

AW = As welded

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.0 x 300	35-55
2.5 x 350	45-80
3.2 x 350	80-115
4.0 x 350	100-155
5.0 x 350	150-220

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.0 x 300	CBOH	150	1.8	557527-2
2.5 x 350	CBOH	90	2.0	557534-2
	SRP	90	2.0	539684-2
3.2 x 350	SRP	55	2.0	539714-2
	CBOX	120	4.3	557565-2
4.0 x 450	SRP	40	2.9	539691-2
	CBOX	80	5.7	557589-2

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.