

# Limarosta 309S

## Key Features

- All positional Electrode (except vertical down) suitable for welding 300 series stainless steel and C-Mn to Stainless steel dissimilar welds
- Excellent wetting characteristics
- High resistance to porosity

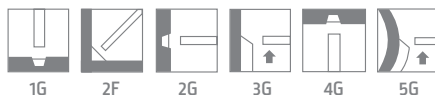
## Typical Applications

- Dissimilar welding
- Cladding
- Butter layer

## Conformances

**AWS A5.4:** E309L-17  
**AS/NZS 4854-A:** E 23 12 L R 22

## Welding Positions



## Diameter / Packaging

Diameter mm	Length mm	Part Number	Packaging
2.5	350	557534-1	CB 2.0 kg (6 x CB per carton)
3.2	350	557565-1	CB 4.2 kg (3 x CB per carton)
4.0	450	557589-1	CB 5.6 kg (3 x CB per carton)

## Mechanical Properties

	Yield Strength MPa	Tensile Strength MPa	Elongation %	Charpy V-Notch J @ +20°C
<b>Requirements - AWS</b>	-	520 min	30 min	-
<b>Requirements - AS/NZS</b>	320 min	510 min	25 min	-
<b>Typical Results - As Welded</b>	440	580	35	50

## Deposit Composition

	%C	%Mn	%Si	%P	%S
<b>Typical Results - As Welded</b>	0.03	0.9	1.0	0.025	0.01
	%Ni	%Cr	FN (acc.WRC 1992)		
<b>Typical Results - As Welded</b>	12.5	23.0	8-15		

## Typical Operation Procedures

Polarity	Current (amps)		
	2.5mm	3.2mm	4.0mm
DC+	70-90	100-120	140-160