Arosta® 309S

TOP FEATURES

- For welding stainless steel to mild steel and root runs in clad steel.
- Applicable for root passes in N alloyed AISI 304LN steels.
- Excellent weldability and self releasing slag.
- High resistance to embrittlement.
- Weldable on AC and DC+ polarity.

CLASSIFICATION

AWS A5.4	E309L-16
EN ISO 3581-A	E 23 12 L R 32

CURRENT TYPE

AC/DC+

WELDING POSITIONS

All position, except vertical down

APPROVALS

ABS	BV	TÜV
+	+	+

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

C	Mn	Si	Cr	Ni	FN (acc. WRC 1992)
0.02	0.8	0.8	23.5	12.5	12-20

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	0.2% Proof strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)		
					+20°C	-20°C	-120°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	480	560	40	60	50	40

AW = As welded

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 350	40-75
3.2 x 350	60-110
4.0 x 350	80-150
5.0 x 350	140-220

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 350	CBOH	90	2.0	528374-2
3.2 x 350	CBOX	120	4.3	528381-2
4.0 x 450	CBOX	80	5.7	528497-2

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.