

# CLEARINOX E 309L

## TOP FEATURES

- Suitable for root pass
- Lower porosity, good striking and restriking
- Excellent slag removal

## CLASSIFICATION

AWS A5.4 E309L-17  
EN ISO 3581-A E 23 12 L R 2 2

## CURRENT TYPE

DC+

## WELDING POSITIONS

Flat and horizontal

## APPROVALS

ABS	BV	DNV	TÜV	DB
+	+	+	+	+

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

C	Mn	Si	P	S	Cr	Ni	Ferrite
0.03	0.9	0.8	0.025	0.01	24	13	8-15

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	0.2% Proof strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) +20°C
AWS A5.4	AW	not specified	≥520	≥30	not specified
EN ISO 3581-A	AW	≥320	≥510	≥25	not specified
Typical values	AW	465	565	41	57

AW = As welded

## OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 300	70-90
3.2 x 350	100-120
4.0 x 350	150-170

## PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 300	VPMD	90	1.8	W000387155
3.2 x 350	VPMD	55	2.0	W000387156

### 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](http://www.lincolnelectric.eu) for any updated information.