

For Dissimilar Metal such as Stainless Steel and Mild Steel

APPLICATIONS

Welding of clad side of SUS304 class clad steel.

Welding of dissimilar metal such as SUS304 type stainless steel.

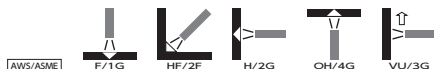
CHARACTERISTICS

S-309L·R is a Low Carbon-24%Cr-13%Ni covered electrode

GUIDELINES FOR USAGE

1. Welding is operated in either AC or DC electrode positive polarity.
2. Electrodes should be dried at 150~250°C for 60 minutes before use.
3. Dirt such as oil, grease and dust should be completely removed from groove.
4. Preheat is not necessary, interpass temperature should be less than 150°C
5. Excessively wide weaving may cause welding defects. Keep weaving width to less than 2.5 times electrode diameter. Arc length should be kept as short as possible.

WELDING POSITION



■ TYPICAL CHEMICAL COMPOSITION OF WELD METAL (%)

C	Si	Mn	P	S	Ni	Cr	Mo	Cu	Other
0.03	0.37	1.52	0.020	0.008	13.0	24.4	0.09	0.09	—

■ TYPICAL MECHANICAL PROPERTIES OF WELD METAL

Yield Strength, MPa	Tensile Strength, MPa	Elongation, %	Charpy 2V-notch at 0°C, J
445	582	36	88

■ SIZES & RECOMMENDED CURRENT RANGE<AC or DC(+)>

Diameter (mm)		3.2	4.0	5.0
Length (mm)		350	350	350
Current A	F / H-fillet	80~100	110~140	140~170
	V-up, OH	70~80	100~130	—

Identification color : End-yellow green, secondary-blue