

EI 309L

Coated Electrode for Stainless Steels -

Standards

AWS/ASME SFA - 5.4	E309L-16
EN ISO 3581 - A	E 23 12 L R 12
TS EN ISO 3581 - A	E 23 12 L R 12
DIN M. No.	1.4337

Approvals & Certificates

TUV	BV	CWB
CE	DNV-GL	GOST
DB		

Properties and Applications

Electrode for joining dissimilar steels (austenitic steels to ferritic steels) and for austenitic claddings on ferritic steels. Weld metal consists of austenite with approx. 15% delta-ferrite. Claddings on unalloyed and low alloy steels are already corrosion resistant in the first layer. Highest operating temperature for joints between dissimilar steels is 300°C. In case of higher temperatures use ENI 422 electrodes. Fine metal droplet transfer, good fusion of joint faces, finely ripped bead surface, easy slag removal, easy arc striking and restriking.

Typical Chemical Values of Weld Metal


Type of Analysis	C	Si	Mn	CR	Ni
Weld Deposit	0.03	0.90	1.10	23.00	12.50

Typical Mechanical Values of Weld Metal

Test Condition	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A5 (%)	Charpy V-Notch Properties (J)
As welded	450	570	40	20°C → 60


Application Information

Welding Positions



PA PB PC PD PE PF

Polarity:



Welding Parameters & Efficiency

Diameter x Length (mm)	Current (A)
2.50x250	50-80
2.50x300	50-80
3.25x300	80-120
3.25x350	80-120
4.00x350	100-165
5.00x350	140-220

Packaging Information

Product Code	Diameter x Length (mm)	Quantity per Box	Box Gross Weight (kg)	Boxes per Outer Box	Outer Box Gross Weight (kg)	Packaging Type
13008GBEM2	2.50x300	53 pcs	0.00	10	0.00	
13008GDEM2	2.50x300	137 pcs	2.62	3	8.00	Plastic Box
13008GJEM2	2.50x300	96 pcs	1.79	9	16.30	VAC Box
13008MBEM2	3.25x300	28 pcs	1.11	10	0.00	
13008MDEM2	3.25x300	81 pcs	2.62	3	8.00	Plastic Box
13008MJEM2	3.25x300	57 pcs	1.79	9	16.30	VAC Box
13008NBEM2	3.25x350	28 pcs	1.11	10	0.00	

13008NDEM2	3.25x350	67 pcs	2.64	3	8.10	Plastic Box
13008NEEM2	3.25x350	134 pcs	5.21	3	15.80	Plastic Box
13008NJEM2	3.25x350	54 pcs	2.04	9	18.60	VAC Box
13008QBEM2	4.00x350	19 pcs	1.11	10	0.00	
13008QEEM2	4.00x350	92 pcs	5.21	3	15.80	Plastic Box
13008QJEM2	4.00x350	37 pcs	2.04	9	18.60	VAC Box
13008TEEM2	5.00x350	58 pcs	5.21	3	15.80	Plastic Box
13008TJEM2	5.00x350	23 pcs	2.04	9	18.60	VAC Box

Storage & Re-Drying Information

It can be dried maximum 5 times.
 It should be stored in a dry room (relative humidity < 50%, room temperature > 20°C) on wooden pallets.
 It has to be dried at 350°C for 2 hours.