

AK E309L-16

Description: A super-low carbon stainless steel electrode designed to weld Cr23Ni13 and similar composition type steels, the carbon content of its deposit metal is $\leq 0.04\%$. With excellent operation and processing properties. Its weld metal with excellent corrosion and pores resistance performance.

Application: Used to weld similar composition steels, clad steels, and dissimilar steels to manufacture petrochemical equipment.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	Mo	Cr	Cu
Requirement	0.04	1.0	0.5- 2.5	0.03	0.04	12.0-14.0	0.75	22.0-25.0	0.75
Actual Result	0.021	0.63	0.92	0.012	0.018	12.90	0.12	24.1	0.15

Typical Mechanical Properties:

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	≥ 510		≥ 25	
Actual Result	580		40	

Recommended welding parameters:

Diameter/mm		2.5	3.2	4.0
Welding current/A	F/H	60-80	80-120	100-150
	V/ OH	40-70	60-100	80-130