

AK E309L-17

Description: Rutile coated stick electrode with approx. 115 % yield. Austenitic weld metal with approx. 15 % δ -ferrite. Resistant to intergranular corrosion up to 400 °C. Scale resistant up to 1050 °C. The lowest permissible operating temperature is -60 °C. Maximum permissible operating temperature of 350 °C.

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	0.036	0.76	1.42	0.011	0.025	12.59	0.03	23.42	0.04

Typical Mechanical Properties:

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	≥ 520		≥30	
Actual Result	610		35	