



OK 309L

SMAW

OK 309L electrodes have a heavy coating and produce a concave weld bead with fine ripple. The slag is virtually self-cleaning. They are suitable for welding carbon to stainless steel and as the first layer when cladding.

Welding Current

DC+, AC OCV 55V



PACKING/ORDERING INFORMATION				
Part Number	Dia (mm)	Inner Carton (kg)	Carton Weight (kg)	Pallet Weight (kg)
6498252030	2.5	1.7	10.2	785.4
6498323020	3.2	4.3	12.9	851.4
6498403020	4.0	4.3	12.9	851.4

CLASSIFICATIONS	TYPICAL ALL WELD METAL COMPOSITION (%)	TYPICAL MECH. PROPERTIES ALL WELD METAL
<u>SFA/AWS A5.4</u> E309L-16 <u>EN 1600</u> E23 12 L R 3 2	C 0.02 Si 0.8 Mn 0.9 Cr 24.0 Ni 12.5	<u>Yield Stress, Mpa</u> 470 <u>Tensile Strength, Mpa</u> 580 <u>Elongation, %</u> 32 <u>Charpy V</u> Test Temps, °C Impact Values, J +20 50 -10 40

WELDING PARAMETERS							
Diameter (mm)	Length (mm)	Welding Current, A	Arc Voltage, V	N. Kg Weld Metal/(kg) Electrodes	B. No. Of Electrodes/(kg) Weld Metal	H. Kg Weld Metal/(hour) Arc Time	T. Burn-off time, (secs)/ Electrode
2.5	300	50-90	28	0.60	85.0	1.1	38
3.2	350	90-120	29	0.60	45.0	1.6	51
4.0	350	130-180	31	0.60	29.0	2.5	51
5.0	350	160-240	32	0.60	19.0	3.3	58

