



LA309L

STANDARD

AWS A5.22 E309L T1-1 ; E309L T1-4

CHARACTERISTICS

Excellent operating properties, good appearance and slight spatter, corrosive resistance

APPLICATION

With excellent corrosive resistance, LA309L is suitable for build-up welding of special steel, carbon or low alloy steel, base welding of stainless steel seams or similar materials.

TYPICAL CHEMICAL COMPOSITION (%)

| C | Mn | Si | Cr | Ni | Mo | S&P |
|-------|------|------|-------|-------|------|-------|
| 0.030 | 1.21 | 0.59 | 23.11 | 13.56 | 0.04 | ≤0.03 |

MECHANICAL PROPERTIES: (CO2 SHIELDED)

| Strength of Extension σ_b (Mpa) | Ductility δ_5 (%) |
|--|--------------------------|
| ≥520 | ≥35 |
| 559 | 42 |

WELDING PROCEDURE PARAMETERS

| Diameter(mm) | Amperage(A) | Voltage(V) |
|--------------|-------------|------------|
| Φ1.2 | 140-260 | 24-32 |
| Φ1.6 | 200-300 | 27-34 |

NOTES

1. CO2 purity≥99.5% , gas-flow≥20L/Min.
2. Deposited metal is unmachinable.
3. Pay attention to wind-resistance.
4. Remove the greasy dirt and moisture.