



LZ309L

STANDARD

AWS A5.22 E309L T1-1 ; GB/T 17853 E309L T1-1

CHARACTERISTICS

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

APPLICATION

With excellent corrosive resistance, LZ309L 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	1.26	0.58	23.15	13.58	0.05	≤0.03

MECHANICAL PROPERTIES: (CO₂ SHIELDED)

Strength of Extension σ_b (Mpa)	Ductility δ_5 (%)
≥520	≥35
590	30

WELDING PROCEDURE PARAMETERS

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

PACKING

1. 1.2/ 1.6mm: 15kg/spool