

S - 309L.16

SHIELDED METAL ARC WELDING CONSUMABLE
FOR WELDING OF DISSIMILAR METALS
STAINLESS STEELS AND CARBON STEELS
OR STAINLESS STEELS AND LOW ALLOY METALS



❖ Specification

AWS A5.4	E309L-16
JIS Z3221	ES309L-16
EN 1600	E 12 12 L R

❖ Applications

S-309L.16N is designed for welding of dissimilar metals such as Stainless steels and carbon steels or stainless steels and low alloy steels

❖ Characteristics on Usage

1. S-308L.16N is a lime- titania type electrode.
2. S-309L.16N is a lime- titania type electrode for dissimilar welding such as stainless steel to carbon steel or low-alloy steels, and for under-layer welding on cladded side groove of cladded stainless steel.

❖ Note on Usage

1. it is mostly effective to proceed with welding. Keeping the arc as short as possible in flat position.
2. Remove dirt such as oil and dust from the groove.
3. Dry the electrode at 350°C(662°F) for 60 minutes before use.

❖ Type of Current

AC or DC+

❖ Packing

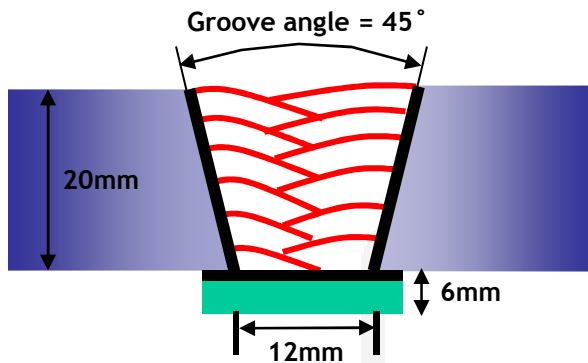
Packet	2.5kg(5.5lbs)
Carton	2.5kg(5.5lbs) X 4 : 10kg(22lbs)



Mechanical Properties & Chemical Composition of All Weld Metal

❖ Welding Conditions

Method by AWS Spec.



Diameter(mm)	: 4.0mm
Amp./ Volt.	: 140/25
Travel speed(Cm/min)	: 13~18
Pre-Heat(°C)	: R.T.
Interpass Temp.(°C)	: 150±15
Position	: Flat
Polarity	: AC or DC+

[Joint Preparation & Layer Details]

❖ Mechanical Properties of All weld metal

Consumable	Tensile Test		CVN Impact Test (Joule)	
	TS(MPa)	EI(%)	-20 °C	-60 °C
S-309L.16	584	40.4	50	42
AWS A5.4 E309L-XX	≥ 520	≥ 30	Not Specified	

❖ Chemical Analysis of All weld metal(wt%)

Consumable	Chemical Composition (%)								
	C	Si	Mn	P	S	Ni	Cr	Mo	Cu
S-309L.16	0.025	0.72	0.92	0.023	0.012	12.64	23.55	0.10	0.09
AWS A5.4 E309L-XX	≤0.04	≤1.0	0.5 ~2.5	≤0.04	≤0.03	12.0 ~14.0	22.0 ~25.0	≤ 0.75	≤ 0.75

This information is provided solely for the purpose of confirming product conformance with applicable standards. The serviceability of a product or structure utilizing this type of information is and must be the sole responsibility of the builder/user. Many variables beyond the control of HYUNDAI WELDING CO., LTD. affect the results obtained in applying this type of information. These variables include, but are not limited to, welding procedure, shielding gas, plate chemistry and temperature, weldment design, fabrication methods and service requirements.

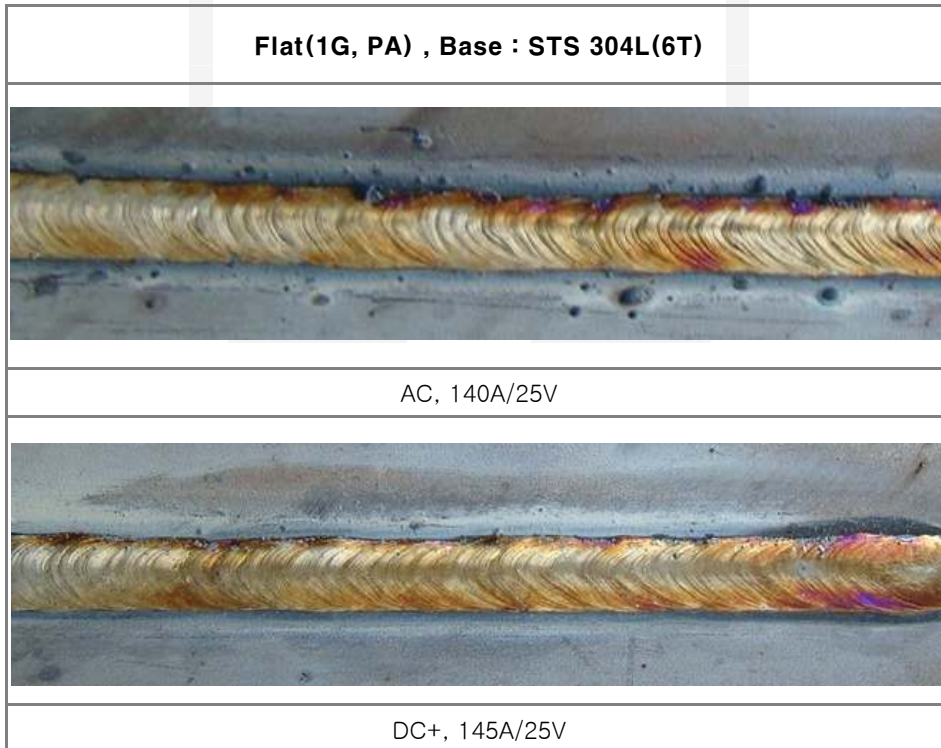


**Mechanical Properties
& Chemical Composition of All Weld Metal**

❖ **δ – Ferrite No.**

Consumable	Diagram			FERITSCOPE MP-30 * (FISCHER)
	Schaeffler	Delong	WRC(1992)	
S-309L.16	12.0	19.0	12.9	15~16

❖ **Bead Appearance**



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Approvals

❖ AUTHORIZED APPROVAL DETAILS

Consumable	KR	ABS	LR
S-309L.16	RD309L 2.0~5.0	AWS A5.4 E309L-16 2.0~5.0	SS/CMn 2.0~5.0
	BV	DNV	GL
	UP(E309L-16) 2.0~5.0	309L 2.0~5.0	4332 2.0~5.0
	NK	CWB	TUV
	KD309L 2.0~5.0	CSA W48-06 E309L-16 2.0~5.0	EN 1600 E 23 12 L R 2.0~5.0
	CE	DB	CCS
	EN 1600 E 23 12 L R 2.0~5.0	E12 12 L R (1.4332) DIN EN 1600 2.0~5.0	309L 2.0~5.0

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