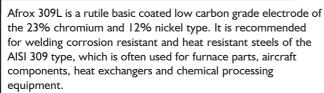
PRODUCT DATA SHEET

AFROX 309L



Afrox 309L can also be used for welding dissimilar carbon manganese steels and low alloy steels, welding stainless steels to mild steels and as a buffer for hardfacing applications.



CLASSIFICATIONS

AWS	A5.4	E309L-17	
SABS	1293	E23.12 R 26	
BS	EN 1600	E 23 12 LR	

APPROVALS

TUV (Kenblatt number 3234.00)

South African Bureau of Standards (SABS 1293 and ISO 9001).

CHEMICAL ANALYSIS

% Carbon	0.03 max	
% Manganese	0.5 - 2.5	
% Silicon	0.90 max	
% Chromium	22.0 - 25.0	

% Nickel	12.0 - 14.0
% Sulphur	0.025 max
% Phosphorous	0.025 max

TYPICAL MECHANICAL PROPERTIES (ALL WELD METAL IN THE AS WELDED CONDITION)

0,2% Proof Stress	420 MPa min	
Tensile Strength	550 - 650 MPa	
% Elongation on 4D	30 min	
Charpy V-Notch at +20°C	55J min	
Charpy V-Notch at -70°C	40J min	
Hardness VPN	170 - 200	

PACKING DATA

(DC + AC 70 OCV min)

Diameter (mm)	Electrode Length (mm)	Current Amps	Item Number IKg Electrode Pack	Item Number Multi-Kg pack	Pack Mass (Kg)
2.5	300	40 - 80	072-772	075-772	3 x 4
3.25	350	70 - 105	072-773	075-773	3 x 4
4	350	90 - 145	-	075-774	3 x 4
5	350	140 - 190	-	075-775	3 x 4

The information contained or otherwise referenced herein is presented only as typical without guarantee or warranty, and Afrox expressly disclaims any liability incurred from any reliance thereon. No data is to be construed as recommended for any welding condition or technique not controlled by Afrox.

