

## MIDALLOY CHROMAX E309L-16 COATED ELECTRODE

### CLASSIFICATION

- AWS 5.4 Class E309L-16 / ASME SFA 5.4 Class E309L-16/ ASME Sec. IX, F4, A9 UNS W30913

### DESCRIPTION

- MIDALLOY CHROMAX E309L-16 is AC-DC titania (i.e. rutile-type) coated electrode
- MIDALLOY CHROMAX E309L-16 produces a smooth arc and excellent slag removal.
- Low carbon content value is controlled to provide added corrosion resistance.

### APPLICATION

- For welding or repairing alloy AISI 309L
- Dissimilar metal combinations of carbon and low alloy steels to stainless steels for services under 500°F.
- Weld metal overlay to obtain an 18-8 nominal deposit chemistry on carbon steel. Note: A minimum of 2 layers are required to obtain less than 0.04%C.

### TYPICAL CHEMISTRY

C	Cr	Ni	Mo	Mn	Si	P	S	Cu	N
.03	23.5	12.3	.10	1.7	.50	.020	.010	.10	.06

### FERRITE CONTENT 5-15 WRC 1992

### TYPICAL MECHANICAL PROPERTIES

TENSILE STRENGTH	82,500 PSI
YIELD STRENGTH	57,500 PSI
ELONGATION IN 2"	38%

### RECOMMENDED WELDING PARAMETERS

DIAMETER	AMPERAGE	
	FLAT	VERTICAL & OVERHEAD
3/32"	70-85	65-75
1/8"	85-110	80-90
5/32"	110-140	100-120
3/16"	120-160	110-130

### STANDARD PACKAGING

- 3/32" - 8 lb. can, 48 lb. Carton
- 1/8", 5/32", 3/16" - 10 lb. Can, 60 lb. Carton

12-1-08

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