

ESAB 309

ESAB 309 is a basic coated, all positional electrode depositing a weld metal of the type 23Cr-13Ni. The weld deposit is extremely tough, resistant to corrosion and oxidation at elevated temperatures, up to 1100°C.

Specifications

Classifications	SFA/AWS A5.4 : E309-15
Welding Current	DC+
Ferrite Content	10-18 FN
Alloy Type	Austenitic Cr-Ni
Coating Type	Basic

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr
0.05	0.80	0.70	13.20	23.80

Deposition Data

Diameter	Current
2.5 x 350.0 mm	60-100 A
3.15 x 350.0 mm	80-120 A
4.0 x 350.0 mm	120-170 A