

CORE-BRIGHT 309L

Designed primarily for overlay applications on carbon steel. May also be used for welding 309 stainless and joining dissimilar metals.

Specifications	
Classifications	AWS A5.22 : E309LTO-3
Approvals	ASME SFA 5.22 AWS A5.22 : E309LTO-3 CERTIFIED BY C.W.B.- AWS A5.22

Approvals are based on factory location. Please contact ESAB for more information.

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
As Welded	440 MPa	630 MPa	34 %

Deposition Data							
Diameter	Current	Voltage	Wire Feed Speed	Deposition Efficiency (%)	Deposition Type	TTW Dist.	Deposition Rate
1.2 mm	110 A	26 V	762 cm/min	86 %	Spray Transfer	19 mm	2.6 kg/h
1.2 mm	150 A	27 V	1016 cm/min	86 %	Spray Transfer	19 mm	3.67 kg/h
1.2 mm	180 A	27 V	1270 cm/min	87 %	Spray Transfer	19 mm	4.45 kg/h
1.6 mm	150 A	27 V	508 cm/min	87 %	Spray Transfer	19 mm	3.08 kg/h
1.6 mm	210 A	28 V	762 cm/min	87 %	Spray Transfer	19 mm	4.67 kg/h
1.6 mm	270 A	29 V	1016 cm/min	85 %	Spray Transfer	19 mm	6.12 kg/h
2.4 mm	250 A	26 V	284 cm/min	85 %	Spray Transfer	25.4 mm	3.8 kg/h
2.4 mm	250 A	26 V	338 cm/min	89 %	Spray Transfer	38 mm	4.5 kg/h
2.4 mm	300 A	28 V	345 cm/min	85 %	Spray Transfer	25.4 mm	4.6 kg/h
2.4 mm	300 A	28 V	402 cm/min	89 %	Spray Transfer	38 mm	6.1 kg/h
2.4 mm	350 A	29 V	467 cm/min	88 %	Spray Transfer	25.4 mm	6.3 kg/h
2.4 mm	350 A	29 V	577 cm/min	87 %	Spray Transfer	38 mm	7.8 kg/h
2.4 mm	400 A	30 V	561 cm/min	85 %	Spray Transfer	25.4 mm	7.3 kg/h
2.4 mm	400 A	30 V	767 cm/min	87 %	Spray Transfer	38 mm	10.3 kg/h
2.4 mm	450 A	30 V	693 cm/min	85 %	Spray Transfer	25.4 mm	9.3 kg/h
2.4 mm	450 A	30 V	871 cm/min	87 %	Spray Transfer	38 mm	11.7 kg/h
2.0 mm	210 A	24 V	348 cm/min	86 %	Spray Transfer	19 mm	3.2 kg/h
2.0 mm	250 A	26 V	460 cm/min	87 %	Spray Transfer	19 mm	4.3 kg/h
2.0 mm	300 A	27 V	599 cm/min	85 %	Spray Transfer	19 mm	5.4 kg/h