

TL 309

International Standards:

AWS SFA 5.4:	E 309-16
JIS Z 3221	: D 309-16
DIN 8556	: E 23 12 R 26
EN 1600	: E 23 12 R 26

Applications and Properties :

The weld metal of TL 309 contains more Cr & Ni than TL 308 / TL 308L. The microstructure containing suitable quantity of ferrite, gives it an excellent resistance to hot cracking. It is suitable for welding of dissimilar metals of mild steel and stainless steel, hardening alloy steel and steel with poor weldability.

Aplikasi dan Penggunaan :

Hasil pengelasan TL 309 memiliki kandungan Cr & Ni lebih tinggi dari TL 308 / TL 308L. Struktur mikronya mengandung ferrite dan memiliki ketahanan yang sangat baik terhadap keretakan. Sangat cocok untuk menyambung stainless steel dengan mild steel, pengerasan baja paduan dan baja yang sulit dilas.

Typical Chemical Analysis of Deposited Metal (%) :

C	Mn	Si	Cr	Ni	P	S
0,05	1,52	0,37	23,52	13,86	0,010	0,010

Typical Mechanical Properties of Deposited Metal :

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation (%)	Impact Value (Joule)
-	580	41	-

Size & Recommended Current Range (DC or AC) :

Size (mm)	2,6 x 300	3,2 x 350	4,0 x 350
Amperages (Amp)	50 - 85	80 - 120	100 - 150
Weight / pack (kgs)	4,5	5	5
Weight / carton (kgs)	18	20	20

Welding Positions :


Attention!
Redrying: 200°C/2h



SYMBOL OF QUALITY

Manufactured by:

PT. Lion Superior Electrodes

Jl. Raya Bekasi Km. 24,5 (Cakung), Jakarta 13910 - Indonesia

Telp: 021-4600779, 4600784, Fax: 021-4600785

email: Marketing@lionweld.com, Lse@lionweld.com