

TL 309L

International Standards:

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

Applications and Properties :

TL 309L is usually used for joining stainless steels to non alloy or low alloy steels. The corrosion resistance is important in surfacing & is dependent on the composition of the weld metal obtained. It is possible in practice to obtain full resistance to intergranular corrosion due to the low carbon content of the weld metal.

Aplikasi dan Penggunaan :

TL 309L sangat cocok untuk pengelasan baja stainless steel dengan baja karbon, di mana ketahanan terhadap korosi merupakan prioritas karena komposisi kimia dari hasil las. Kandungan karbonnya rendah dan hasil las memiliki ketahanan terhadap korosi intergranular.

Typical Chemical Analysis of Deposited Metal (%) :

C	Mn	Si	Cr	Ni	P	S
0,03	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

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