

Limarosta® 309S

EMR
SAHARA®

SMAW

CLASSIFICATION

AWS A5.4	E309L-17	A-Nr	8	Mat-Nr	1.4332
ISO 3581-A	E 23 12 L R 3 2	F-Nr	5		
		9606 FM	5		

TEMPERATURE RANGE

Pressurized parts : -20...+300°C
Oxidation resistance : n.a

GENERAL DESCRIPTION

A rutile-basic all position CrNi over-alloyed buffer electrode
Developed for welding stainless steel to mild steel and for clad steel
Self releasing slag
Excellent side wall wetting, no undercut, mirror like bead appearance
High resistance to porosity
Weldable on AC and DC+ polarity
Also available in vacuum sealed Sahara ReadyPack® [SRP]

WELDING POSITIONS (ISO/ASME)



PA/1G



PB/2F



PC/2G



PF/3Gu



PE/4G



PH/5Gu

CURRENT TYPE

AC/DC +

APPROVALS

DNV	GL	LR	RMRS	TÜV
309L	4432	SS/CMn	SS/CMn	+

CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL

C	Mn	Si	Cr	Ni	FN (acc.WRC 1992)
0.02	0.8	1.0	23.0	12.5	10-20

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition	0.2% Proof strength (N/mm²)	Tensile strength (N/mm²)	Elongation (%)	Impact ISO-V(J)	
					+20°C	-20°C
Required: AWS A5.4 ISO 3581-A Typical values	AW	not required min. 320 480	min. 520 min. 510 560	min. 30 min. 25 40	not required not required 55	- 50

PACKAGING AND AVAILABLE SIZES

	Diameter (mm)	Length (mm)	2.0	2.5	3.2	4.0	5.0
Carton + PE foil	Pieces / unit		200	125	135	85	55
	Net weight/unit (kg)		2.3	2.8	4.9	5.9	6.0
SRP	Pieces / unit		-	65	50	28	-
	Net weight/unit (kg)		-	1.5	1.8	2.0	-
Linc Can™	Pieces / unit		-	197	127	79	-
	Net weight/unit (kg)		-	4.4	4.5	5.4	-

Identification Imprint: 309L-17 / LIMAROSTA 309 S Tip Color: sea green

Limarosta®309S: rev. C-EN25-01/02/16