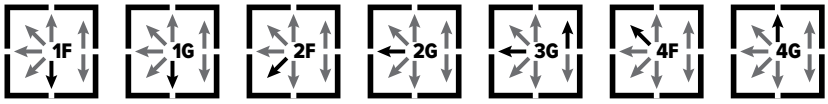
STAINLESS STEEL

HYPERARC 309L



Summary

HYPERARC 309L is a stainless steel electrode formulated for welding stainless steels to carbon or low-alloy steels. They are ideal for situations that demand a transition between the two metals, as they provide a buffer layer preventing brittle weld zones. The low carbon content reduces the risk of carbide precipitation, promoting resistance to intergranular corrosion. These electrodes yield a smooth arc, consistent performance, and are suitable for both overlay work and joining dissimilar steel grades.

Typical Applications

- Welding of dissimilar metals
- Stainless steel overlays on carbon and low-alloy steels
- Joining stainless steel to carbon or low-alloy steel
- High-temperature service equipment
- Heat exchangers and furnace parts

Classification

- AS/NZS 4854: B - ES316L-16

Standards

- B - ES316L-16
- AWS/ASME SFA5.4: E309L-16

Operating Polarity

- AC & DCEP

Operating Data

ELECTRODE SIZE	WELDING CURRENT RANGE
2.6mm	50A-90A
3.2mm	80A-120A

Typical Chemical Composition (%)

C	Mn	Si	P	S	Ni
0.020	0.800	0.770	0.020	0.010	12.000
Cr	**Mo**	**Cu**			
24.000	0.030	0.150			

Typical Mechanical Analysis

YIELD STRENGTH	321
TENSILE STRENGTH	691
ELONGATION	40

Packaging Info

SKU	ELECTRODE SIZE	WEIGHT	DESCRIPTION
U63014	2.6mm	2kg	HYPERARC 309L STAINLESS STEEL ELECTRODES 2.6MM 2KG
U63015	3.2mm	2kg	HYPERARC 309L STAINLESS STEEL ELECTRODES 3.2MM 2KG