

TECH-ROD 309L

- I. **DESCRIPTION:** Tech-Rod 309L gives a weld deposit similar to 309, with reduced carbon levels (.04% maximum) that offer increased resistance to intergranular corrosion. Type 309L is ideal for joining stainless steels to themselves or to carbon or low alloy steels. Tech-Rod 309L is preferred to Tech-Rod 309 for cladding over carbon or low alloy steels, as well as dissimilar joints, which undergo heat treatment.
- II. **APPROVALS:** Manufactured under Quality System approved by ASME, ISO9001. Meets AWS 5.4 Class E309L-16.

II. CHEMICAL COMPOSITION

Carbon	.035
Manganese	1.58
Silicon	.53
Chromium	23.45
Nickel	12.6
Sulfur	.021
Phosphorus	.024
Iron	Balance

MECHANICAL PROPERTIES

Tensile Strength	
88,500 PSI	555 MPA
Yield Strength	
59,000 PSI	410 MPA
Elongation	36%

IV. WELDING PARAMETERS

Direct Current
Electrode + Ve

AMPERAGES:

3/32"	65-75
1/8"	90-105
5/32"	120-135
3/16"	135-155

(For vertical welding amperages are to be reduced by 10 to 15 amps)

V. PACKAGES AVAILABLE:

3/16"-10# can, 5/32"-10# can, 1/8"-10# Can, 3/32"-8# can