

VALIANT

VALIANTWELD-E309L

AWS:A5.4:E309L-16 IS-5206:E23.12 LR 26

A stainless steel electrode depositing an extra low carbon 24 Cr-12Ni weld metal. The weld metal has excellent mechanical properties and possesses good oxidation and scaling resistance at elevated temperatures.

CHEMICAL COMPOSITION

C	Mn	Si	Cr	Ni
0.03	1.60	0.50	23.6	12.8

MECHANICAL PROPERTIES

UTS (Kg/mm ²)	EI (L = 4D)%
58.2	38.0

WELDING PARAMETERS

	Size (mm)	Current (Amp.)
AC/DC (-)	4.00 X 350	110-140
	3.15 X 350	80-110
	2.50 X 350	60-80

APPLICATION

Ideally suited for welding stainless steels, wrought and cast materials of similar composition, welding of 18/8 type stainless steels to carbon steels for buffer layers, for welding lad side of 18/8 clad stainless etc.

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