

# ES 309L-17

Type Acid-rutile

SMAW

E309L-17

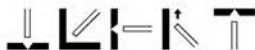
**ESWECO**  
*The Art of Welding*

## Description

ES 309L-17 is an over-alloyed, stainless electrode for welding stainless to mild steel and low-alloy steel, for surfacing mild steel and for welding the root runs in clad steel. The electrode has excellent weldability in all positions except vertical down, on both AC and DC.

### Current

DC+, AC OCV 55 V



## Classifications

EN 1600	E 23 12 L R 3 2
SFA/AWS A5.4	E309L-17
Werkstoff Nr.	1.4332

## Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Cu
<0.03	0.7	0.9	24.0	13.0	<0.3	<0.3

## Typical mech. Properties all weld metal

Yield stress, MPa	470
Tensile strength, MPa	580
Elongation A5, %	32

### Charpy V

Test temps, °C	Impact values, J
+20	50
-10	40

Ferrite content FN 12-22

## Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V
2.5	300	50-90	28
3.2	350	90-120	29
4.0	350	130-180	31
4.0	450	130-200	31