

# ES 309L-15

Type Basic

SMAW  
E309L-15

**ESWECO**  
*The Art of Welding*

## Description

ES 309L-15 is a basic coated, stainless electrode for welding steels of the 24Cr13Ni type, for welding transition layers when surfacing mild steel with stainless, for joining dissimilar steels and welding root runs in the stainless side of clad steels.

## Current

DC+



## Classifications

EN 1600	E 23 12 L B 4 2
SFA/AWS A5.4	E309L-15
Werkstoff Nr.	1.4332

## Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Cu
<0.04	0.5	2.2	24.0	13.0	<0.5	<0.3

## Typical mech. Properties all weld metal

Yield stress, MPa	470
Tensile strength, MPa	600
Elongation A4, %	35

## Charpy V

Test temps, °C	Impact values, J
+20	75
-80	55

Ferrite content FN 12-22

## Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V
2.5	300	50-80	22
3.2	350	80-110	24
4.0	350	100-150	26