

AI-0209

Specifications

AS/ANS 1553.3 : E309L-16

AWS/ASME A5.4 : E309L-16

Description and Applications

Rutile coated electrode for welding steels containing 16-26% Cr and 8-14% Ni. AI 209 is a smooth flowing electrode demonstrating excellent slag control and low splatter. Its high alloy content enables deposits that have optimum tensile - elongation properties.

For welding a wide range of stainless steels to alloy steels. Also ideal for rebuilding worn sections prior to hardfacing.

Typical Weldmetal Analysis

| C | Mn | Cr | Fe | Ni | Si |
|------|-----|----|-----|----|-----|
| 0.02 | 1.1 | 23 | Bal | 13 | 0.7 |

Mechanical Properties of Weldmetal

| | As Welded |
|-----------------------|-----------|
| Tensile Strength | 560MPa |
| Yield Strength (0.2%) | 450Mpa |
| Elongation | 40% (4d) |

Welding Parameters

| Diameter (mm) | Current type | Amps |
|---------------|--------------|---------|
| 2.5 | DC /AC | 50-80 |
| 3.2 | DC /AC | 80-110 |
| 4.0 | DC /AC | 110-140 |

Also available as MIG wire: **AI-1709** and Open arc wire: **AI-1509**

Welding Positions

(1G, 1F) Downhand/flat position, (2F) Horizontal position, (2G) Horizontal vertical position, (4G) Overhead position, (3G, 3F, 5G up) Vertical Position Up

Disclaimer

All figures in this datasheet should be considered indicative only. No guarantee is made as to their accuracy.

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ALLOYS INTERNATIONAL PTY LTD

25 Raymond Road Laverton North Victoria 3026

Telephone: +61 3 8368 2222 | Facsimile: +61 3 8368 2200

ABN 53 112 712 286

sales@alloysint.com.au | www.alloysint.com.au