

# LINOX 309L

## TOP FEATURES

- Smooth weld appearance
- Minimum spatter and high resistance to porosity
- Good side wall wetting, no undercut

## CLASSIFICATION

AWS A5.4 E 309L-17  
EN ISO 3581-A E 23 12 L R 32

## CURRENT TYPE

AC / DC +

## WELDING POSITIONS

All positions

## APPROVALS

ABS

+

## CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Si	Cr	Ni	P	S	FN (acc.WRC 1992)
≤0.040	0.9	0.9	23.5	12.2	≤0.025	≤0.025	5-20

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) +20°C
Typical values	AW	≥400	≥520	≥30	≥47

AW = As welded

## PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Pieces / unit	Weight (kg)	Item number
2.5x350	CBOH	90	2.0	620144
	VPMD	90	2.0	620156
3.2x350	CBOH	55	2.0	620145
	VPMD	55	2.0	620157
4.0x450	CBOH	40	2.9	620147
	VPMD	40	2.9	620158

## TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing. Please refer to [www.lincolnelectric.eu](http://www.lincolnelectric.eu) for any updated information.

LINOX 309L-EN-01/07/22