

# GEMINI 309 L

## Typical Applications And Characteristics

GEMINI 309L is a rutile extra-low carbon coated electrode for welding corrosion-resistant and heat resistant Cr-and CrNi-steels. The high level of alloying elements makes this electrode also suitable for welding Cr-and CrNi steel to mild steel welding CrNi-clad steel very smooth weld with clean edge. Low spatter loss and excellent slag removability.

Typical All-Weld Metal Properties		
Composition (%)		Mechanical
C	0.02	Yield Strength 517 N/mm <sup>2</sup>
Mn	0.92	Tensile strength 570 N/mm <sup>2</sup>
Si	0.63	Elongation 35 %
Ni	13.00	
Cr	23.50	

## Typical welding current

AC or DC+					
Ø/L (mm)	2.0/300	2.6/300	3.2/350	4.0/350	5.0/350
Current min/max (A)	30/50	40/70	70/100	110/140	120/160

International Standard	Printing	Welding Positions
AWS/ASME SF-A5.4 E309L-16	G-309L/E309L-16	Flat, horizontal, vertical-up and overhead