

GEMINI 309 L

AWS/SFA5.4 E 309L-16

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 Stress	520	N/mm2
Mn	0.92	Tensile strength	570	N/mm2
Si	0.63	Elongation	30	%
Ni	13.00			
Cr	23.50			

AC or DC±					
∅/L (mm)	2.0X300	2.6X300	3.2X350	4.0X350	5.0X350
Current min/max (A)	30-50	40-70	70-100	110-140	120-160

Typical welding current			
Approval	Color	End	Silver
	Coding	Side	Blue
	Printing	G-309L/E 309L-16	
	Welding Positions	Flat, horizontal, vertical-up and overhead	