

AFROX 309L Class C5 Schedule K



Afrox 309L Class C5 Schedule K is a rutile basic coated low carbon electrode for welding 23% Cr 12% Ni type stainless steel, it has been specially formulated for applications requiring low temperature properties at -90°C for use in cryogenic applications. It is batch tested for tensile, charpy impact values and lateral expansion at -90°C.

CLASSIFICATION

AWS A5.4 E309L-17

CHEMICAL ANALYSIS

% Carbon	0.030	% Chromium	23.200
% Manganese	0.580	% Molybdenum	0.090
% Silicon	0.740	% Nickel	12.100
% Sulphur	0.010	% Copper	0.040
% Phosphorous	0.010		

**TYPICAL MECHANICAL PROPERTIES
(ALL WELD METAL IN THE AS WELDED
CONDITION)**

	AC	DC
2% Proof Stress	529 MPa	530 MPa
Tensile Strength	639 MPa	629 MPa
Elongation %	36.0%	35.5%
Charpy V-Notch at -90°C	33J	33J
Lateral Expansion	0.23 mm	0.20 mm
Moisture Content	0.116%	0.116%

PACKING DATA

Diameter (mm)	Electrode Length (mm)	Current Amps	Item Number Multi-Kg pack	Pack Mass (Kg)
2.5	350	40 - 80	087-772	3 x 4
3.2	350	70 - 105	087-773	3 x 4
4.0	350	90 - 145	087-774	3 x 4

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