

**AFROX 309L**



Afrox 309L is a rutile basic coated low carbon grade electrode of the 23% chromium and 12% nickel type. It is recommended for welding corrosion resistant and heat resistant steels of the AISI 309 type, which is often used for furnace parts, aircraft components, heat exchangers and chemical processing equipment.

Afrox 309L can also be used for welding dissimilar carbon manganese steels and low alloy steels, welding stainless steels to mild steels and as a buffer for hardfacing applications.

**CLASSIFICATIONS**

AWS	A5.4	E309L-17
SABS	1293	E23.12 R 26
BS	EN 1600	E 23 12 LR

**APPROVALS**

TUV (Kenblatt number 3234.00)  
 South African Bureau of Standards (SABS 1293 and ISO 9001).

**CHEMICAL ANALYSIS**

% Carbon	0.03 max	% Nickel	12.0 - 14.0
% Manganese	0.5 - 2.5	% Sulphur	0.025 max
% Silicon	0.90 max	% Phosphorous	0.025 max
% Chromium	22.0 - 25.0		

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

0,2% Proof Stress	420 MPa min
Tensile Strength	550 - 650 MPa
% Elongation on 4D	30 min
Charpy V-Notch at +20°C	55J min
Charpy V-Notch at -70°C	40J min
Hardness VPN	170 - 200

**PACKING DATA**

(DC + AC 70 OCV min)

Diameter (mm)	Electrode Length (mm)	Current Amps	Item Number 1Kg Electrode Pack	Item Number Multi-Kg pack	Pack Mass (Kg)
2.5	300	40 - 80	072-772	075-772	3 x 4
3.25	350	70 - 105	072-773	075-773	3 x 4
4	350	90 - 145	-	075-774	3 x 4
5	350	140 - 190	-	075-775	3 x 4

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