

ESAB Stainless Steel Electrodes

ESAB 308L Plus, 309 Plus, 309L Plus & 316L Plus

Rutile based stainless steel electrodes for Shielded Metal Arc Welding

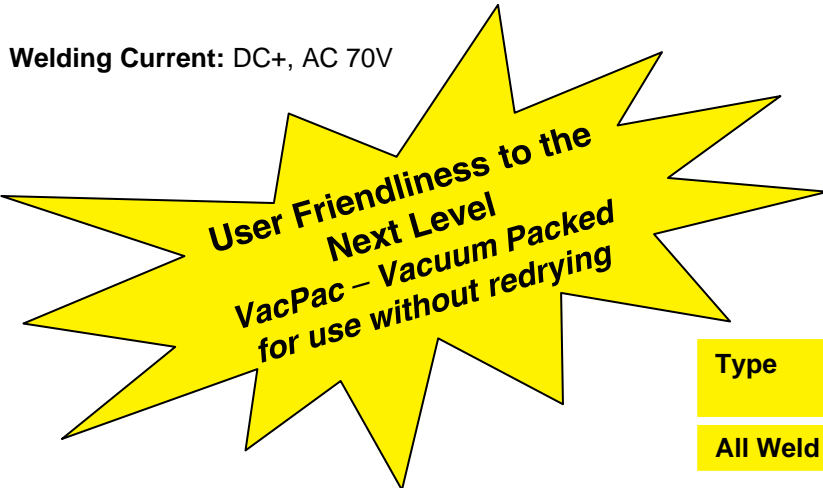
ESAB 308L Plus AWS A5.4 E308L-16

ESAB 309 Plus AWS A5.4 E309-16

ESAB 309L Plus AWS A5.4 E309L-16

ESAB 316L Plus AWS A5.4 E316L-16

Welding Current: DC+, AC 70V



Description

ESAB Plus series of stainless steel electrodes are rutile based electrodes for joining stainless steels of similar composition. ESAB 309L/309 Plus is also suitable for dissimilar joining with unalloyed or low alloyed steels and for transition layers when surfacing mild or low alloyed steel with stainless steel weld metal.

ESAB Plus range of electrodes have easy arc initiation / re-striking characteristics and are resistant to porosity in adverse working conditions.

Applications

- General Stainless Steel Fabrication
- Dissimilar Metals Joining
- Surfacing

Type	308L Plus	309 Plus	309L Plus	316L Plus
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All Weld Metal Chemical Composition (%)

C	0.03	0.03	0.03	0.03
Si	0.75	0.90	0.95	0.70
Mn	0.65	0.90	0.80	0.65
Cr	18.8	23.5	23.7	18.0
Ni	9.7	12.6	12.7	11.8
Mo	-	-	-	2.5

All Weld Metal Mechanical Properties

UTS (MPa)	580	620	600	580
% EL	45	35	35	38

- Smooth running characteristics
- Stable on both AC & DC welding
- Easy Arc initiation & Re-striking
- Good weld bead appearance
- Resistance to porosity in adverse conditions

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