

ARCALOY 309L-16 AWS A5.4: E309L-16/E309-16

FEATURES

Arcaloy 309L-16 is used for welding carbon and low alloy steels to stainless steels. This can be done provided the service temperature does not exceed about 700°F (371°C). Post weld heat treatment should only be performed after due consideration.

* This item is subject to Industry Alloy Surcharges

TYPICAL MECHANICAL PROPERTIES

Yield Stress	65 ksi, 450 MPa
Tensile Strength	85 ksi, 590 MPa
Elongation in 2"	37%

CLASSIFICATIONS AND APPROVALS

- ASME II SFA A5.4: E309L-16/E309-16
- AWS A5.4: E309L-16/E309-16
- ASME IX F No. 5
- Certified by CWB to CSA W48

WELDING PROCESS

- SMAW (Stick)

WELD METAL ANALYSIS

C	0.03%
Mn	1.8%
Si	0.45%
Cr	23.5%
Ni	13.5%
Mo	0.3%
Cu	0.1%
Ferrite	9 FN

INDUSTRIES

- General Fabrication

ARCALOY 309L-16 continued

WELDING PARAMETERS

Diameter in (mm)	Flat Amps	Vertical Amps	Overhead Amps
1/16 (1.6)	20 - 35	15 - 25	20 - 30
5/64 (2.0)	30 - 50	25 - 35	30 - 40
3/32 (2.4)	40 - 70	35-50 (Amps)	40 - 60
1/8 (3.2)	65 - 100	55 - 70	60 - 85
5/32 (4.0)	100 - 145	85 - 100	95 - 120
3/16 (4.8)	130 - 190	100 - 115	125 - 150
1/4 (6.4)	205 - 290		

PART NUMBER / PRODUCT INFORMATION

Part Number	Description	UPC
251053302	* AC 309L-16 3/32X9X6#HS	662303013356
251053203	AC 309L-16 3/32X12X10#HS	662303074616
251051801	AC 309L-16 1/8X14X10#HS	662303013332
251055307	AC 309L-16 5/32X14X10#HS	662303013363
251053104	AC 309L-16 3/16X14X10#HS	662303013349
251051405	AC 309L-16 1/4X14X10#HS	662303013325

*Special Order