



Product Data Sheet
NSS-309L / NSW-309L
AWS E309L-16

DESCRIPTION

NSS-309L is a lime-titania type electrode, which gives extra low carbon 25% Cr-12% Ni austenitic weld metal virtually free from spatter. Because of extra low carbon content, the deposited metal has more excellent resistance to the inter crystalline corrosion than that of ordinary 309 type. Peeling-off of the slag is very good.

APPLICATIONS

Welding of AISI309S and heat resisting cast steel. First-layer welding of stainless clad steel, for corrosion resistant build-up welding of mild steel.

INSTRUCTION FOR WELDING

- (1) It is necessary not to use excessive current in order to prevent the dilution from base metal in the case of welding of dissimilar metals and clad steel.

Typical Chemical Composition of Weld Metal (%):

C	Si	Mn	Cr	Ni	Mo
0.03	0.37	1.88	24.02	13.21	-

Typical Mechanical Properties of Weld Metal:

Tensile Strength N/mm2 (Ksi)	Elongation (%)
558 (81)	44

Size and Recommended Current Range (AC or DC +):

Diameter (mm)	1.6	2.0	2.5	3.2	4.0	5.0	
Length (mm)	255	255	300	350	350	350	
Ampere	Flat	20-50	20-50	50-80	70-110	100-150	130-180
	V&OH	15-45	15-45	45-75	65-105	95-140	-

Welding Positions:

FLAT, FILLET, VERTICAL UP, HORIZONTAL, OVERHEAD

APPROVALS: ABS

Packing:

EXPORT (1.6-2.5mm): 16 Kg corrugated box, with 4 units of 4 Kg plastic container.