



LKE-309L-16

LINKWELD ALLOYS INC.

AWS	A5.4 E309L-16
EN	EN1600 E 23 12 L 1 2
JIS	Z3221 D309L-16

Characteristics:

The weld metal of LKE-309L contains more Cr, Ni than LKE-308L. The microstructure containing suitable quantity of ferrite, gives it an excellent resistance to hot cracking. It is suitable for welding of dissimilar metals, hardening alloy steel and steel with poor weldability.

Applications:

It is suitable for welding of stainless steel piping in refineries and chemical plants.

Notes on Usage:

1. Dry the electrodes at 200-250°C for 60 minutes and keep at 100-150°C before use.
2. Use lower currents for dissimilar metals welding.

Typical chemical composition of weld metal (wt%)

C	Mn	Si	P	S	Cr	Ni
0.03	1.26	0.65	0.02	0.01	23.76	13.44

Typical mechanical properties of weld metal

TS N/mm ²	EL %
600	41

Welding position:



Sizes and recommended current range (AC or DC <+>)

Diameter (mm)		2.0	2.6	3.2	4.0	5.0
Length (mm)		250	300	350	350	350
Amps	F	30-55	50-85	80-120	100-150	140-180
	V&OH	20-50	45-80	70-110	90-135	-
Weight per pack(kg)		4/5	4/5	5	5	5
Weight per carton (kg)		20	20	20	20	20