

**Technical  
data sheet**

080122MBA

**Coated SMAW Electrode****WA TETRA V 309L-E****CLASSIFICATION**

ASME IIC SFA 5.4 / AWS A 5.4:	E309L-16
EN ISO 3581-A:	E 23 12 L R 3 2
Equivalent Material number:	1.4332
ASME IX Qualification	QW432 F-N° 5    QW442 A-N° 8

**DESCRIPTION**

- Rutile coated stainless steel SMAW electrode
- 24% chromium - 13% nickel - low carbon deposit
- Optimum versatility for welding in the flat & horizontal positions with high cosmetic finish
- Excellent weldability in all positions
- Weldable on AC and DC
- Complements Welding Alloys cored wires TETRA S 309L-G and TETRA V 309L-G
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**APPLICATIONS**

- Welding stainless steels of similar composition or ferritic stainless steels.
- Joining stainless steels to mild and low-alloyed steels.
- Rebuilding and buffering before cladding or hardfacing.
- Maintenance on "hard-to-weld" steels.

**Examples**

Dissimilar welds between stainless steel types 304, 304L, 316, 316L, 318, 316Ti, 321, 410 or ferritic stainless steel types 1.4713, 1.4724, 1.4742, 3Cr12, to non or low alloyed CMn steels, for service temperatures up to 400°C.

ISO/TR 15608:    Groups 1, 2, 3 and 4 to groups 7, 8 and 10.  
                           Group 7 to groups 8 and 10.

**TYPICAL ALL-WELD METAL ANALYSIS [%]**

C	Si	Mn	Cr	Ni	Fe
0.03	0.8	0.7	22.5	12.5	Bal.

Typical ferrite level:    15 FN

**MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES**

Rm [MPa]	Rp0.2% [MPa]	A <sub>5</sub> [%]	CVN [J]
560	400	35	-20°C: 32

**TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES**

Rm [MPa]	Rp0.2% [MPa]	A <sub>5</sub> [%]	CVN [J]
590	490	40	-20°C: 45

**OPERATING CONDITIONS**

Electrode Ø x L [mm]	2.0 x 300	2.5 x 350	3.2 x 350	4.0 x 350	5.0 x 450
Current [A]	45	70	100	135	180
= +	~ 70V				

Re-drying: 1h at 250°C, if necessary.

**WELDING POSITIONS**

EN ISO 6947:    PA, PB, PC, PD, PE, PF, PG  
 ASME IX:        1F, 1G, 2F, 2G, 3F, 3G, 4F, 4G, 5G

**PACKAGING**

Electrode Ø x L [mm]	2.5 x 350	3.2 x 350	4.0 x 350
Weight/box [kg]	5.0	5.0	5.0

Other packaging and other sizes: please consult us

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.