

PRODUCT INFORMATION

STAVINOX 309L-16

AWS A:5.4: E309L-16
EN ISO 3581-A - E 23 12 L R 1 2

DESCRIPTION

STAVINOX 309L-16 is a rutile-coated stainless steel MMA electrode with excellent weldability and a self-peeling slag. It is known for its outstanding performance, boasting best-in-class mechanical properties, and is particularly suitable for joining dissimilar steels.

WELDING POSITIONS



Suitable for AC and DC+ welding in all standard positions (PA, PB, PC, PD, PE, PF), with a stable, spatter-free arc and self-releasing slag.

TYPICAL WELD METAL COMPOSITION

C	0.04 Max	Cr	22.0-25.0
Si	1.00 Max	Ni	12.0-14.0
Mn	0.50-2.5	Mo	0.75 Max
S	0.03 Max	Cu	0.75 Max
P	0.04 Max		

TYPICAL MECHANICAL PROPERTIES

Tensile Strength	>520 N/mm²
Elongation	>30%

MATERIAL TO BE WELDED

STAVINOX 309L-16 is particularly suited to joining dissimilar steels, such as mild/carbon steel to austenitic stainless steel, and for buffer/cladding layers. Root weldability verified; maximum wall thickness 40mm. Type of current: DC+ (G+). Material group per CR ISO 15608: Group 8.1 (without Mo/without N), welded to Group 1.1 and Group 1.2. Highest short-term operating temperature 350°C; lowest operating temperature -60°C, as for parent metal. (Source: TÜV-Verband-Kennblatt 20140.00, dated 22.02.2024.)

AVAILABLE FORMATS

RC3092520-SV	2.5mm 2kg VP
RC3093220-SV	3.2mm 2kg VP
RC3094020-SV	4.0mm 2kg VP

For further information, contact Weldability-SIF on +44 1462 482200 or email orders@weldability-sif.com



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