BASINOX 309L

MMA Electrodes
Stainless and Heat resistant steels

BASINOX 309L is a semi-basic MMA electrode depositing a low C – 22/24%Cr – 12/14%Ni weld metal with approx. 12% delta-ferrite promoting high resistance to hot cracking.
This electrode has three main applications:
- Buffer layers and claddings on unalloyed and low-alloy steels which are already corrosion resistant in the first layer.
- Dissimilar joints (austenitic steels to ferritic steels) with operating temperatures up to 300ºC. In case of higher temperatures, use SUPRANEL 182.
- Welding of stainless steels of similar composition.

The weld deposit carbon content is 0.04% max. Excellent weldability with a spatter free arc, self-releasing slag, combined with a very smooth bead appearance and BASINOX 309L is well-suited for positional welding.

Low hydrogen electrode with characteristics and applications suitable for dissimilar steels. The low carbon content improves deposit characteristics.

Classification	
EN ISO	3581-A: E 23 12 L B 22
AWS	A5.4: E 309L-15

Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Ferrite
0.025	1.4	0.35	≤ 0.03	≤ 0.025	22.5	13	5-15

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J) 20 °C
As Welded	≥ 320	≥ 520	≥ 30	≥ 60

Materials

A312 TP309S; Dissimilar steels (Ferritic to Austenitic steels), cladding.

Storage

Keep dry and avoid condensation.

Re-dry 250-300 °C for 1 hour, 5 times max.

Current condition and welding position

DC+

Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weightn(kg/1000)	VPMD	
				PC	Code
2.5	300	45-70	17.40	105	W000287981
3.2	350	65-120	34.50	60	W000287982
4.0	350	115-140	49.60	40	W000287983