

S - 309L.15

SHIELDED METAL ARC WELDING CONSUMABLE
FOR WELDING OF DISSIMILAR METALS
STAINLESS STEELS AND CARBON STEELS
OR STAINLESS STEELS AND LOW ALLOY METALS

2020.12



❖ Specification

AWS A5.4	E309L-15
JIS Z 3221	ES309L-15
EN ISO 3581-A	E 23 12 L B

❖ Applications

S-309L.15 is designed for welding of dissimilar metals such as Stainless steels and carbon steels or stainless steels and low alloy steels

❖ Characteristics on Usage

S-309L.15 is basic type electrode.

S-309L.15 is for dissimilar welding such as stainless steel to Carbon steel or low-alloy steels, and for under-layer welding on cladded side groove of cladded stainless steel.

❖ Note on Usage

1. it is mostly effective to proceed with welding. Keeping the arc as short as possible in flat position.
2. Remove dirt such as oil and dust from the groove.
3. Dry the electrode at 350°C (662°F) for 60 minutes before use.

❖ Type of Current

DC+

❖ Packing

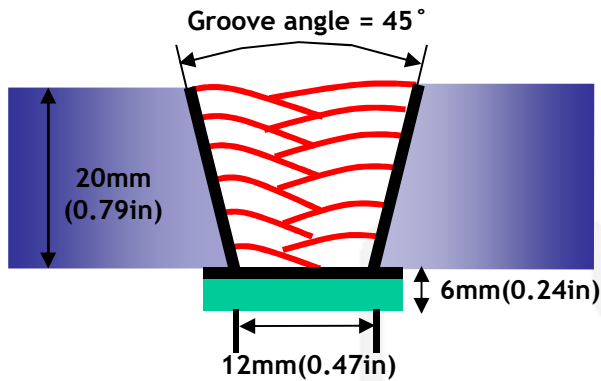
Packet	2.5kg(5.5lbs)
Carton	2.5kg(5.5lbs) X 4 : 10kg(22lbs)



Mechanical Properties & Chemical Composition of All Weld Metal

❖ Welding Conditions

Method by AWS Spec.



Diameter	: 4.0mm(5/32in)
Amp./ Volt.	: 125/24
Travel speed	: 13~18(Cm/min)
Pre-Heat	: R.T .
Interpass Temp.	: Max 150°C(302°F)
Position	: Flat
Polarity	: DC+

[Joint Preparation & Layer Details]

❖ Mechanical Properties of All weld metal

Consumable	Tensile Test			CVN Impact Test Joule(ft·lbs)
	YS MPa (lbs/in ²)	TS MPa (lbs/in ²)	El(%)	-115°C(-175°F)
S-309L.15	440(64,000)	610(88,000)	40.0	45(33)
AWS A5.4 E309L-XX	-	≥520(75,000)	≥ 30	Not Specified

❖ Chemical Analysis of All weld metal(wt%)

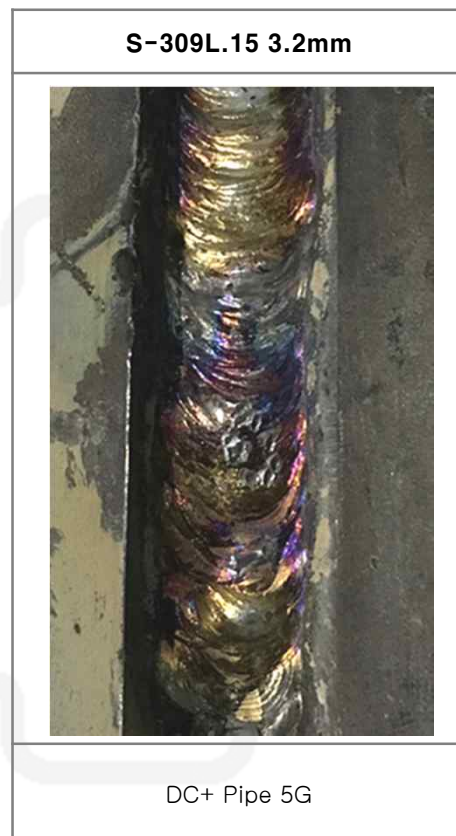
Consumable	Chemical Composition (%)								
	C	Si	Mn	P	S	Ni	Cr	Mo	Cu
S-309L.15	0.03	0.60	1.25	0.015	0.010	13.0	23.5	0.02	0.02
AWS A5.4 E309L-XX	≤0.04	≤1.0	0.5 ~2.5	≤0.04	≤0.03	12.0 ~14.0	22.0 ~25.0	≤ 0.75	≤ 0.75

This information is provided solely for the purpose of confirming product conformance with applicable standards. The serviceability of a product or structure utilizing this type of information is and must be the sole responsibility of the builder/user. Many variables beyond the control of HYUNDAI WELDING CO., LTD. affect the results obtained in applying this type of information. These variables include, but are not limited to, welding procedure, shielding gas, plate chemistry and temperature, weldment design, fabrication methods and service requirements.



Bead Appearance

❖ **Bead Appearance**



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