

# NOUVE<sup>®</sup> 309L-16

Designation

**AWS A5.4 E309L**  
**UNS No. W30910**

Welding Positions



## Features

- Excellent arc characteristics
- Low moisture re-absorption
- Low spatter level
- Low smoke level
- Quick & easy slag removal
- Radiography quality

## Applications

Used extensively in heat resistance casting, clad stainless steels.  
Dissimilar joints between stainless steels to carbon or low alloys steels

## Recommended Welding Techniques

GENERAL : Electrode positive, work negative (DCEP)  
ARC LENGTH : Short arc  
STORAGE : Re-dry electrodes 250°C to 300°C for 1 hour before use.

## Weld Metal Chemistry

	Carbon	Chromium	Nickel	Molybdenum	Nb+Ta	Manganese	Silicon	Phosphorous	Sulphur	Copper
AWS	0.04	22-25	12-14	0.75	-	0.5-2.5	0.5-2.5	0.04	0.03	0.75
Typical	0.024	22.84	13.56	0.62	-	2.08	0.74	0.024	0.018	0.66

## Mechanical Properties (as welded)

MECHANICAL TESTS	Tensile Strength	Elongation % in 2"
AWS SPEC	520	30
TYPICAL	590	35