

AMERIARC

Ameri 309 A1

INTERNATIONAL CLASSIFICATIONS

AWS/ASME A 5.4 E 309L – 16
ISO 3581: E23 12 LR 32

EN: E23 12 LR 32

DESCRIPTION & APPLICATION:

Ameri 309 A1 is a low carbon rutile coated electrode. It gives a filler metal of the Cr-Ni type. Weld beads are highly resistant to oxidation at operating temperatures up to 1000°C. It can be used in all positions. The weld metal has a high resistance to cracking.

Ameri 309 A1 is an ideal electrode especially designed for welding pipes, plates and tanks that are used in chemical, petrochemical, food and paper industries.

WELD METAL CHEMICAL ANALYSIS (TYPICAL WEIGHT %):

C	Mn	Si	Cr	Ni	Fe
.04	1.8	.6	23.3	12.5	bal

Flux Color : Grey

TYPICAL MECHANICAL PROPERTIES:

Undiluted Weld Metal	Maximum Value Up to:
Tensile Strength	110,000 PSI (750 MPa)
Yield Strength	76,000 PSI (530 MPa)
Elongation	32%
Hardness	Brinell 219

WELDING CURRENT & INSTRUCTIONS:

Recommended Current : DC Reverse (+) or AC

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Minimum Amperage	55	75	90
Maximum Amperage	75	110	140

PACKAGING & DIMENSIONS:

Dimensions	Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
	Length (mm)	12" (300)	14"(350)	14"(350)
Packaging	Electrodes / lb	8.8	8.8	8.8
	Electrodes / kg	4.0	4.0	4.0