

# HABCO 309L-16 (S)

## MICRO-DENSE COATED SPRAY TRANSFER SUPER STAINLESS ELECTRODE

### FEATURES

The high alloy content of the **HABCO 309L** stainless steel electrodes make them exceptional alloys for welding similar and dissimilar alloys in wrought or cast form. The high quality, balanced chemistry of these electrodes gives them superior welding characteristics. They are designed with a special, spray type arc transfer that results in less heat input because of the closer arc gap that can be maintained while welding. This also makes them easier to use in all positions. **HABCO 309L** electrodes have arc stabilizers in the coating that make them outstanding when used on AC machines. The slag is very easy to remove – virtually self-lifting. The special coating insures dense, porosity free deposits. It not only retards moisture pick-up, but will automatically readjust the moisture content to a safe level once it is brought back to a drier atmosphere, without the need for re-baking.

### APPLICATIONS

Used to weld 309 stainless steel base metal. This type of stainless steel is used for high temperature applications as in oven and kiln linings, boiler and furnace parts. They are used to join many of the 300 and 400 series of stainless steel to carbon steel. Used for welding the clad side of 18/8 clad steels and applying stainless steel sheet linings to carbon steel shells. Also used on Ch-20 HH castings.

### INSTRUCTIONS

Clean weld area of foreign material. A 60° bevel is used when welding parts 3/16" or heavier. DC reverse polarity is preferred. Use lowest amp setting possible to get good bead contour, which is usually about 20% less than for mild steel. In fabricating, tack weld at close intervals using next smallest diameter electrode. Chip slag and stainless steel wire brush tacks before welding. Use stringer beads where possible and keep close arc gap while welding. Avoid excess heat build-up. Thin sheets may have to be clamped with chill blocks to avoid excessive distortion.

**Tensile Strength: up to 85,000 Psi (60 kg/mm<sup>2</sup>)**

**Yield Strength: up to 55,000 Psi (39 kg/mm<sup>2</sup>)**

**Elongation in 2": 40%**

**Corrosion Resistance: Very Good**

**Heat Resistance: Excellent - up to 2000°F (1093°C)**

**Current: AC or DC +**

<b>Amperage:</b>	<b>40-80</b>	<b>60-120</b>	<b>90-150</b>	<b>140-220</b>
<b>Diameters: (in)</b>	<b>3/32</b>	<b>1/8</b>	<b>5/32</b>	<b>3/16</b>
<b>(mm)</b>	<b>2.5</b>	<b>3.25</b>	<b>4.0</b>	<b>5.0</b>

- Available in TIG and WIRE form
- Certified by CWB to CSA STANDARD W48
- Conforms to AWS A5.9 E309L-16