EXECUTIVE PLUS 309/309L

STAINLESS STEEL

COATED ELECTRODE TECHNICAL DATA SHEET

DESCRIPTION

Executive PLUS electrodes have a unique European formulation designed for the most discriminating operator. Improved silica-titania (AC-DC) coating resists moisture pick up. A careful selection of raw materials and an advanced manufacturing process guarantees the electrodes resist starting porosity; even under extreme humidity and when left exposed to the atmosphere for prolonged periods. Noble chemistry improves corrosion resistance in challenging environments and actual weld deposit chemistries as well as controlled ferrites with each batch.

Executive PLUS 309/309L provides superior weldability, low spatter and smooth beads with easy slag removal and can be used in all positions when welding as root runs in butt welds and thin plates in general. If postweld heat treatment of the carbon steel is essential, the total procedure, welding and heat treatment should be proven prior to implementation.

APPLICATIONS & FEATURES

Commonly used for welding dissimilar steels, such as joining Type 304 to mild or low alloy steel, welding the clad side of Type 304-clad steels, welding the first layer of E308L weld cladding and applying stainless steel sheet linings to carbon steel.

Executive PLUS features include: high current-carrying capacity, a smooth finely rippled weld bead, self-detaching slag with no residue, elimination of starting porosity, superior arc stability with excellent strike and restrike characteristics.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Cr	Ni	Mn	Si
<0.025	24.5	13.0	0.8	<0.9

Tensile Strength:	85,000 PSI min	**Yield Strength:**	56,000 PSI min	**Elongation:**	37%
Charpy V-Notch:	40 ft/lb at at -76°F / -60°C				

TYPICAL WELDING PARAMETERS

Process	Diameter	Length	Amperage
SMAW	3/32"	14"	55-85
AC/DC	1/8"	14"	80-120
	5/32"	14"	100-150
	3/16"	14"	125-195

STANDARD PACKAGING & HANDLING

SMAW	.093"	9-lb metal can	27-lb master box
	.125"	9.7-lb metal can	29.1-lb master box
	.156"	10.1-lb metal can	30.3-lb master box
	.187"	10.1-lb metal can	30.3-lb master box



CLASSIFICATION

AWS/SFA 5.4, Class **E309/309L-17**

Certified by the Canadian Welding Bureau (CWB) to AWS A5.4