



Electrodes for Stainless Steel | GEMINI 309L

GEMINI 309L is a rutile extra-low carbon coated electrode for welding corrosion-resistant and heat resistant Cr-and CrNi-steels. The high level of alloying elements makes this electrode also suitable for welding Cr-and CrNi steel to mild steel welding CrNi-clad steel very smooth weld with clean edge. Low spatter loss and excellent slag removability.

TYPICAL ALL-WELD METAL PROPERTIES

COMPOSITION (%)		MECHANICAL	
C – Carbon	0.03	0.2% Proof Stress	480 N/mm ²
Mn - Manganese	1.20	Tensile Strength	600 N/mm ²
Si - Silicon	0.70	Elongation (5xd)	35 %
Ni - Nickel	13.00	Reduction of area	40 %
Cr - Chromium	25.00	Impact strength ISO-V @ +20°C	60 Joule

TYPICAL WELDING CURRENT

AC or DC +/-					
Diameter /Length (mm)	2.0/ 300	2.6/ 300	3.2/ 350	4.0/ 350	5.0/ 350
Current min/ max (A)	30/ 50	40/ 70	70/ 100	110/ 140	120/ 160

INTERNATIONAL STANDARD

MARKINGS & IDENTIFICATION

AWS A5.4	E 309L-16	End Tip Colour	Silver
ISO 3581	E 23 12 LR 26	End Side Colour	Blue
DIN 8556	E 23 12 nC R 26	Printing	G-309L/ E 309L-16

WELDING POSITION

Flat, Horizontal, Vertical-up and overhead

PACKAGING & ORDERING INFORMATION

Size	Packet	Carton
2.0mm	1 kg	20 kgs
2.6mm	1 kg	20 kgs
3.2mm	1 kg	20 kgs
4.0mm	1 kg	20 kgs
5.0mm	1 kg	20 kgs

Disclaimer: The information provided serves as a general guideline. Actual welding parameters may vary depending on the specific characteristics of the welding equipment. Additional variables to consider include weld length, plate thickness, operator proficiency, etc. Users are encouraged to assess their unique circumstances and seek professional advice as needed. It is important to acknowledge that neither we nor our affiliates can be held liable for any misuse or improper application of products.