

## Arcaloy 309L-17 PLUS

Arcaloy 309L-17 Plus electrodes have a heavy coating and produce a concave bead with minimal ripple. The slag is virtually self-cleaning. For welding carbon steel to stainless steel for service below about 315°C (600°F) and for the first layer when cladding.

<b>Approvals</b>	AWS A5.4 E309L-17/E309-17 ASME IX F No. 5 ASME II SFA A5.4 E309L-17/E309-17 CWB E309L-17
<b>Industry</b>	Industrial and General Fabrication

Approvals are based on factory location. Please contact ESAB for more information.

### Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo	Cu
0.025	0.6	0.7	13.5	23.5	0.1	0.1

### Recommended Welding Parameters

Wire Diameter	Flat Amps	Vertical Amps	Overhead Amps
2.4 mm (3/32 in.)	60-85 A	35-50 A	40-60 A
3.2 mm (1/8 in.)	90-120 A	55-70 A	60-85 A
4.0 mm (5/32 in.)	140-165 A	85-100 A	95-120 A