

Arcaloy 309L-15

Arcaloy 309L-15 is used for welding carbon and low alloy steels to stainless steels. This can be done provided the service temperature does not exceed about 700°F (370°). Post weld heat treatment should only be taken with great care. Arcaloy 309L-15 can be used as the first layer of stainless steel on carbon or low alloy steel.

Classifications	AWS A5.4 : E309L-15/E309-15
Approvals	AWS A5.4 E309L-15/E309-15 ASME II SFA A5.4 E309L-15/E309-15 ASME IX F No. 5 QPL MIL-E-22200/2 MIL-309L-15
Industry	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	Ferrite
0.035	1.8	0.5	13.5	24	0.3	0.1	9 FN