



Nexus 309L

23%Cr 12%Ni - Stainless Steel electrode for MMA welding

Rutile Stainless Steel Electrode for the joining of Ferritic and Austenitic steels to themselves and each other. Producing butt welds and mitre finish fillet welds that are smooth and free of spatter.

International Standards

BS EN 1600:1997	AWS A5.4 - 06
E 23 12 LR 3 2	E309L-17

Typical All-Weld Metal Analysis (wt%)

C	Si	Mn	S	P	Cr	Ni	Ferrite
<0.03	0.8	0.7	0.012	0.015	22.5	12.5	12

Typical All-Weld Metal Mechanical Properties

Yield Strength N/mm²	Tensile Strength N/mm²	Elongation %	Impact Strength +20^oC
>400	>560	>35	>60

Welding Positions

Flat butt weld, flat fillet welds, horizontal vertical fillet welds
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Materials

Dissimilar joints between all 300 series to itself and to mild steel, Austenitic Manganese steels, Cromweld 3Cr12
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Packaging

Size mm	2.5 x 300	3.2 x 350	4.0 x 350
Pieces/Package	135	73	48
Pieces/Carton	540	292	192
Kg/Package	2.5	2.5	2.5
Packs/Carton	4	4	4
Kg/Carton	10	10	10

Operating Requirements

DC+ AC(70ocv min)	50 – 80 A	90 – 110 A	120 – 150 A
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Additional Information

CE Certified	Constructional products directive (CPD)
Certification	BS EN 10204:2004 Type 2.2
Material safety data sheet	MSDS 05
Re-dry	2 Hours @ 250^oC if required
Related Nexus Products	MIG Nexus 309LSi TIG Nexus 309L