

Strip Electrode for Electroslag Overlay Welding

BA-STRIP 309L

Classification: EN ISO 14343-A: **B 23 12 L**
SFA-5.9: **EQ309L**

Main Application:

BA-STRIP 309L is a strip electrode for electroslag overlay welding (ESW) recommended to achieve composition similar to AISI 309L corrosion resistant overlay weld deposit on mild steel and low alloy steels.

Typical analysis and chemical composition acc. to EN ISO 14343-A and AWS A5.9: (Weight Percent)

Strip electrode	C	Si	Mn	Mo	Ni	Cr	P	S	Cu total
Typical analysis BA-STRIP 309L	0.015	0.4	1.8	0.1	13.0	23.5	0.020	0.013	0.15
B 23 12 L acc. to ISO 14343-A	0.03	0.65	1.0 – 2.5	0.5	11.0 – 14.0	22.0 – 25.0	0.03	0.02	0.5
EQ309L acc. to AWS A5.9	0.03	0.30 – 0.65	1.0 – 2.5	0.75	12.0 – 14.0	23.0 – 25.0	0.03	0.03	0.75

Base Materials:

Mild steels and low alloy steels.

Suitable flux: BF 44

Flux type suitability is strongly dependent on its application. In combination with the strip electrode the most suitable flux should match the requirements of the plate material as closely as possible under the existing welding conditions. Further information can be obtained from the technical flux data sheets.

Package Forms:

Coils or wound spools as standard package forms for strip electrodes.

Dimensions:

30 x 0.5 mm, 60 x 0.5 mm; sizes and tolerances acc. to ISO 544 and AWS A5.9.

Other dimensions on request.

Strip Electrode Surface:

Smooth finish free from surface defects and foreign matter.