NC-39L PREMIARC™

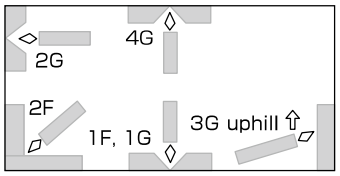
Stick electrode

Features: ▪ Suitable for dissimilar-metal joint and underlaying on ferritic steels

Classification: AWS A5.4 E309L-16

Redrying Conditions: 150~200℃x0.5~1h
Identification color: 1st Yellow green, 2nd Blue white
Polarity: AC, DCEP

Welding Positions:



Packaging data

ϕ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
2.0	250	2	20	11	300W, 125H, 280L
2.6	300	2	20	20	300W, 95H, 330L
3.2	350	5	20	36	175W, 125H, 380L
4.0	350	5	20	55	175W, 115H, 380L
5.0	350	5	20	82	175W, 115H, 380L

Composition (all-weld metal mass%)

	Typical (AC)	Guaranty [a]
C	0.04	0.04
Si	0.42	1.00
Mn	1.6	0.5~2.5
P	0.03	0.04
S	<0.01	0.03
Ni	13.3	12.0~14.0
Cr	23.8	22.0~25.0
Mo	0.18	0.75
Cu	0.09	0.75

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F, 2G	3G uphill, 4G
2.0	50~75	45~65
2.6	75~95	70~90
3.2	85~120	80~115
4.0	110~160	90~140
5.0	150~200	-

All-weld mechanical properties

	Typical (AC)	Guaranty
0.2%YS (MPa)	410	-
TS (MPa)	560	518min.
El on 4d (%)	42	30min.
IV 0℃ (J)	67	-

Approvals

ABS	MG (AWS 5.4 E309L-16)
LR	SS/CMn m (CHEM)
DNV	VL309L, MG
BV	UP (E309L-16)
NK	KD309L