



# EAGLE 309L-16

*Superior High Strength Alloy For Joining Dissimilar Steels*

**CERTIFIED BY CWS TO CSA W48**

## APPLICATIONS

The **EAGLE 309L-16** is for joining dissimilar steels such as stainless to carbon steel.

## PROCEDURE

Use AC or DC Reverse [+] Polarity. Clean weld areas with grinder and groove out cracks using the **EAGLE 188**. Maintain a short arc length and use stringer beads.

## GENERAL CHARACTERISTICS

The **EAGLE 309L MIG** can be used for buffer layers when cladding as well as for joining dissimilar steels.

## TECHNICAL DATA

Tip Color: Plain  
Tensile Strength: Approx. 87,000 psi  
Elongation: Approx. 36%  
Shielding Gas: 75/25 AR/CO<sub>2</sub>  
or 100% CO<sub>2</sub>  
Gas Flow: 30 - 40 CFH

## WELDING PARAMETERS

Current:	AC or DC Reverse [+] Polarity			
Sizes: Inches	3/32	1/8	5/32	3/16
mm	2.50	3.25	4.00	5.00
Amperage:	30-80	60-110	110-150	160-180



≡ HIGH QUALITY WELDING PRODUCTS ≡

10077 - 166 STREET, EDMONTON, ALBERTA T5P 4Y1 • BUS: (780) 481-8082  
FOR TECHNICAL ASSISTANCE CALL US TOLL FREE 1-800-447-1415

REVISED 01 2024