

Description & Applications

Electrode for welding of austenitic stainless and cast steels. Austenitic stainless-steel electrode suitable for welding of dissimilar steels and for depositing austenitic claddings. Weld metal consists of approximately 15% delta ferrite. Highest joining temperature for dissimilar joints is +300 °C. Fine droplet metal transfer, good wash-in of joint sides, finely ripple bead, easily removable slag.

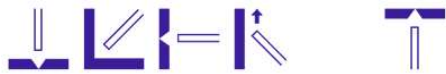
Re-baking: 350 °C ± 20 °C for 2 hours.

Suitable for joining Niobium stabilized stainless steel to high alloy & unalloyed steels, for welding AISI 309 –Nb type steels, straight chrome steels, Joining stainless steel to low alloy steel and carbon steel.

Welding current

AC, DC+

Welding Positions



Classifications

SFA/AWS A5.4 E309Nb-16

All weld metal typical composition, %

C	Si	Mn	Cr	Ni	Nb
0.03	0.80	0.70	24.0	13.0	0.80

All weld metal typical mechanical properties,

Yield strength, MPa	>400
Tensile strength, MPa	520-580
Elongation, %	≥30

Charpy V

Test temperature, °C	+20
Impact values, J	60

Approvals

Welding parameters

Diameter, mm	Length, mm	Welding Current, A	Packet weight, kg	No. of Packet per Carton
2.5	300	45-80	1	10
3.2	350	60-120	1	10
4.0	350	100-150	1	10
5.0	-	-	-	-

- Available in normal & metal can pack.