



SS 309

STAINLESS STEEL ELECTRODE

CLASSIFICATION :

IS : 5206-83 : E 23.12 R26
AWS/A 5.4 : E 309 - 16

APPROVALS :

PDIL EIL TCE
TOYO NPC DESEIN

CHARACTERISTICS :

A rutile type stainless steel electrode suitable for welding of AISI 309 grade in cast or wrought form. The weld-metal has excellent resistance to corrosion and temperatures upto 1100°C. Operates equally well on AC and DC (+) in all conventional positions. Performance and properties are excellent and consistent.

APPLICATIONS :

- * Welding of similar and dissimilar steels, eg. stainless steels to mild steels
- * Clad side of stainless clad steels etc.

RECOMMENDATIONS :

To obtain best results redry the electrodes at 200°C. Use short arc, lower currents and stringer bead technique. Maintain proper interpass temperature in case of dissimilar welding.

CHEMICAL ANALYSIS OF WELD-METAL(%) :

C	Mn	Si	Cr	Ni	Mo	S	P	Cu
0.10	0.5-2.5	1.0	22-25	12-14	0.75	0.03	0.04	0.75
max		max			max	max	max	max

MECHANICAL PROPERTIES OF ALL WELD-METAL (AS PER AWS/A 5.4) :

Ultimate Tensile Strength	Elongation (GL=4d) (%)	CVN Impact Value at 27°C
N/mm ²		Joules
550 min	30 min	70 min

CURRENT CONDITIONS : USE AC OR DC (+)

Size (mm)	2.5x350	3.15x350	4.0x350	5.0x350
Amps	60-80	80-110	110-140	150-180

SPECIAL CHARACTERISTICS :

DELTA FERRITE : 5 FN min

**MODI ARC ELECTRODES CO.**

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SS 309 L

STAINLESS STEEL ELECTRODE

CLASSIFICATION :

IS : 5206-83 : E 23.12L R26
AWS/A 5.4 : E 309L - 16

APPROVALS :

NPC, DNV, PDIL

CHARACTERISTICS :

A rutile type stainless steel electrode suitable for welding of AISI 309 grade in cast or wrought form. The weld-metal has excellent resistance to corrosion and temperatures upto 1100°C. Operates equally well on AC and DC (+) in all conventional positions. Performance and properties are excellent and consistent.

APPLICATIONS :

- * Welding of similar and dissimilar steels, eg., Stainless Steel to mild steel.
- * Clad side of stainless clad steels etc.

RECOMMENDATIONS :

To obtain best results redry the electrodes at 200°C for one hour. Use short arc, lower currents and stringer bead technique. Maintain proper interpass temperature in case of dissimilar welding.

CHEMICAL ANALYSIS OF WELD-METAL(%) :

C	Mn	Si	Cr	Ni	Mo	S	P	Cu
0.04	0.5-2.5	0.90	22-25	12-14	0.75	0.03	0.04	0.75
max		max			max	max	max	max

MECHANICAL PROPERTIES OF ALL WELD-METAL (AS PER AWS/A 5.4) :

Ultimate Tensile Strength	Elongation (GL=4d) (%)	CVN Impact Value at 27°C
N/mm ²		Joules
520 min	30 min	70 min

CURRENT CONDITIONS : USE AC OR DC (+)

Size (mm)	2.5x350	3.15x350	4.0x350	5.0x350
Amps	60-80	80-110	110-140	150-180

SPECIAL CHARACTERISTICS :

DELTA FERRITE : 5 FN min

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SS 309-15

STAINLESS STEEL ELECTRODE

CLASSIFICATION :

IS : 5206-83 : E 23.12 B-20
AWS/A 5.4 : E 309-15

CHARACTERISTICS :

A basic coated electrode for joining stainless steels to mild steels. High strength and corrosion resistance at elevated temperature are special feature. Can be used in all conventional positions.

APPLICATIONS :

- * AISI 309 Grade steels
- * Dissimilar steels
- * Cold steels (specially root run)
- * Austenitic-martensitic steels.

RECOMMENDATIONS :

Use electrode at lower currents of the range. Maintain proper interpass temperature. Clean the weld beads properly. If necessary grind all the top surface. Redry the electrodes at 250°C for one hour.

CHEMICAL ANALYSIS OF WELD-METAL(%) :

C	Mn	Si	Cr	Ni	Mo	S	P	Cu
0.10	0.5-2.5	1.0	22-25	12-14	0.75	0.03	0.04	0.75
max		max			max	max	max	max

MECHANICAL PROPERTIES OF ALL WELD-METAL (AS PER AWS/A 5.4) :

Ultimate Tensile Strength	Elongation (GL=4d) (%)	CVN Impact Value at 27°C
N/mm ²		Joules
550 min	30 min	120 min

CURRENT CONDITIONS : USE DC (+) ONLY

Size (mm)	2.5x350	3.15x350	4.0x350	5.0x350
Amps	50-80	80-110	110-150	160-200

SPECIAL CHARACTERISTICS :

DELTA FERRITE : 5 FN min

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