SUNWELD 309Mo

Stainless Steel Electrode

CLASSIFICATION

AWS/A 5.4 : E 309 Mo-16
IS 5206-83 : E23.12.2 LR 26

CHARACTERISTICS

SUNWELD 309 Mo is a rutile type stainless steel electrode yielding a weld deposit of 25 Cr-12Ni-2.5Mo which has good oxidation resistance up to 1050°C. Operates equally well on DC(+) or AC. Suitable for all conventional welding position.

Special Characteristic: Delta Ferrite 5 to 10 FN

APPLICATIONS

Joining of 309 Mo, 316 type stainless steels, joining of dissimilar steels such as stainless steels to mild steel and low alloy steels. Welding of clad side of AISI 309 Mo grade stainless steels.

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL):

C	Mn	Si	S	P	Ni	Cr	Mo
0.07	1.4	0.46	0.019	0.02	12.9	23.2	2.49

MECHANICAL PROPERTIES OF ALL WELD METAL (TYPICAL)

Ultimate Tensile Strength	Elongation
782.0 N/mm^2	36.40 %

CURRENT RANGE & PACKING DATA:

Size (mm)	Length (mm)	Current(Amp) AC or DC(+)	Quantity of Electrodes in a Carton	Quantity of Electrodes in a Cardboard box
2.50	350	70-90	2 Kg	10 Kg
3.15	450	90-110	2 Kg	10 Kg
4.00	450	110-140	2 Kg	10 Kg
5.00	450	150-180	2 Kg	10 Kg

RECOMMENDATIONS:

Re-dry the electrodes at 200°C for one hour. Use stainless steel wire brush for cleaning the welds.