

SUNWELD 309Cb

Stainless Steel Electrode



CLASSIFICATION

AWS A 5.4 : E 309 Cb-16

IS 5206-83 : E23.12.2 NbR26

CHARACTERISTICS

SUNWELD 309 Cb is a rutile type stainless steel electrode which yield a nominal composition of 25 Cr 12 Ni Nb stabilized weld deposit. The weld metal has excelled resistance to corrosion and temperature up to 1100°C. Presence of Nb provides stabilization against intra granular corrosion.

Special Characteristic: Delta Ferrite 5 to 10 FN

APPLICATIONS

Welding of dissimilar steels such as 18/8 or 18/8 Cb to mild steel, welding the clad side of 18/8 or 18/8Cb steels. Applying sheet lining of 12% Cr steel to mild steels shells and hoppers.

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL):

C	Mn	Si	S	P	Ni	Cr	Cb
0.07	1.30	0.52	0.019	0.02	12.8	23.2	0.78

MECHANICAL PROPERTIES OF ALL WELD METAL (TYPICAL)

Ultimate Tensile Strength	Elongation
586 N/mm ²	36.60 %

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	60-80	2 Kg	10 Kg
3.15	450	80-110	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.