

# RATNA 309

**All position Stainless steel electrode welding for excellent resistant to chemical corrosion and heat corrosion**

**CLASSIFICATION** : AWS/SFA-5.4: E 309-16, DIN 2312R23  
IS-5206: E 23.12R 26 , BS 23.12R

**APPROVAL** : RDSO

**CHARACTERISTICS** : A rutile type, all position electrode giving 24/12 deposit with excellent resistant to chemical corrosion and heat corrosion. Gives stable arc, low spatter, smooth weld profile, easily removable slag. The weld deposit is of radiographic soundness and withstands temperature up to 1100°C.

**APPLICATION** :

- 1) Suitable for welding 24/12 stainless steel grades of AISI 309.
- 2) Welding stainless steel to carbon steel and low alloy steels.
- 3) Clad side of stainless steel etc.
- 4) Root passes of clad steel.

**RE-DRY CONDITION** : Re-Dry the electrode at 250°C for 1 hrs before use.

## ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	S	P	Cr	Ni
0.10 max.	0.50-2.50	1.00 Max	0.030 Max	0.040 Max	22.00-25.00	12.00-14.00

## ALL WELD MECHANICAL PROPERTIES:

UTS (N/mm <sup>2</sup> )	EL % (l=4d)	CHARPY "V" NOTCH IMPACT AT	FERRITE (FN)
550-660	30-45	+20 <sup>0</sup> C : 60-100 J	8-14

## DIEMENSION, CURRENT CONDITION & PACKING DATA

Size(mm) (Dia)	Size(inch) (Dia)	Current Condition (DC-/AC) Amps	kg./pkt.	kg./Case
2.50/ 2.40 X 350	3/ 32" X 14"	50-80	2	20
3.15/ 3.20 X 350	1/ 8" X 14"	75-100	2	20
4.00 X 350	5/ 32" X 14"	110-140	2	20
5.00 X 350	3/ 16" X 14"	150-180	2	20

Customer packing on request.