

RATNA 309Cb

All position rutile type electrode giving 25 Cr-123 Ni-Cb stabilized deposit.

CLASSIFICATION : AWS/SFA-5.4: E 309Nb-16,
IS-5206: E 23.12 Nb R 26

APPROVAL :

CHARACTERISTICS : A rutile type, all position electrode giving 24Cr/12Ni-0.7Cb stabilized. The weld metal has high tensile strength and high creep resistance upto 1100°C. welding with stable arc, low spatter, smooth weld profile, easily removable slag.

APPLICATION :

Welding suitable for similar steels, straight, chrome steels, dissimilar metal joining, Welding suitable for between MS and Low alloy to stainless steels, Overlay and buffer applications etc.

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	Nb
0.12 max.	0.50-2.50	1.00 Max	0.030 Max	0.040 Max	22.00-25.00	12.00-14.00	0.70-1.00

ALL WELD MECHANICAL PROPERTIES:

UTS (N/mm ²)	EL % (l=4d)	CHARPY "V" NOTCH IMPACT AT +20 ⁰ C : 60-100 J	FERRITE (FN)
550 Min.	30 Min.		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.



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