

# RATNA 309L

## Extra low carbon 23Cr/12Ni type stainless steel electrode.

**CLASSIFICATION** : AWS/SFA-5.4: E 309L-16, DIN 23 12 LR 23  
IS-5206: E 23.12LR 26, BS 23 12 LR

**APPROVAL** : LRA, TOYO

**CHARACTERISTICS** : An extra low carbon, all position electrode giving 24/12 deposit with excellent resistance to chemical corrosion, corrosion at elevated temperature and oxidation. Gives stable arc, low spatter, smooth weld profile, easily removable slag. The weld deposits are radiographically sound.

**APPLICATION** :

- 1) Suitable for welding 24/12 stainless steel grades of AISI 309L.
- 2) Welding similar and dissimilar steels eg. Stainless steel to carbon steel and low alloy steels.
- 3) Straight chrome steels.

**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
0.04 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 +20 <sup>0</sup> C : 60-100 J	FERRITE (FN)
520-660	30-45		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.