

RATNA 309Mo

A rutile type all position stainless steel electrode weld deposit 23Cr/12Ni/2.5Mo.

CLASSIFICATION : AWS/SFA-5.4: E 309Mo-16
IS-5206: E 23.12.2R 26

APPROVAL :

CHARACTERISTICS : A rutile type all position electrode giving 25/12/2.5 (Cr/Ni/Mo) weld deposit with increased tensile strength and corrosion resistance properties. Gives smooth and rippled bead, low spatter, stable arc, easily detachable slag coupled with resistance to chemical corrosion and heat.

APPLICATION :

- 1) Suitable for weld dissimilar steels like carbon steel to stainless steel with Mo welding 316 type clad steel AISI 309Mo steel and to weld difficult to weld 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	Mo
0.12 max.	0.50-2.50	1.00 Max	0.030 Max	0.040 Max	22.00-25.00	12.00-14.00	2.00-3.00

ALL WELD MECHANICAL PROPERTIES:

UTS (N/mm ²)	EL % (l=4d)	CHARPY "V" NOTCH IMPACT AT +20 ⁰ C : 50-70 J	FERRITE (FN)
550-660	30-40		8-20

DIEMENSION, CURRENT CONDITION & PACKING DATA

Size(mm) (DXL)	Size(inch) (DXL)	Current Condition (DC+/AC) Amps	kg./pkt.	kg./Case
2.50/ 2.40 X 350	3/ 32" X 14"	60-80	2	20
3.15/ 3.20 X 350	1/ 8" X 14"	80-100	2	20
4.00 X 350	5/ 32" X 14"	120-150	2	20
5.00 X 350	3/ 16" X 14"	150-180	2	20

Customer packing on request.