

## RELINOX 309L

### STAINLESS STEEL STICK WELDING ELECTRODE

Classification : AWS : A 5.4 E 309L-16  
DIN : E2312n CR26  
BS : 23.12LR  
JIS D 309L-16  
Werkstoff Nr. : 1.4332

**Approval** :

**Description** : An extra low carbon, all position giving 24Cr and 12Ni deposit with excellent For welding of low carbon 18/8 stainless steel. AISI 304L intergranular corrosion Resistivity is excellent. The electrodes gives smooth arc, fine bead appearance And shiny finish. Suitable for welding 301L,302L 304L and 308L steel with Having 18/8 with low carbon Content.

**RE-DRY CONDITION** : Re-Dry the electrode at 300°C for 1 hrs, for best results.

#### ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	Ni	Cr	S&P
0.030 Max.	1.50 Max.	1.00 Max.	12.0-14	22.0-25.	0.025 Max

#### ALL WELD MECHANICAL PROPERTIES :

YS (N/mm <sup>2</sup> )	UTS (N/mm <sup>2</sup> )	EL % (l=4xd)	CHARPY "V" NOTCH IMPACT AT
>380	>580	>35	-+20 <sup>0</sup> C : >60 Jouls

#### DIEMENSION, CURRENT CONDITION & PACKING DATA

Size(mm) (DXL)	Size(inch) (DXL)	Current Condition (DC+/AC 70V)	kg/pkt.	kg/Case
2.50/2.40x350	3/32"x14"	50-80	2	10
3.15/3.20x450	1/8"X14"/18"	70-110	2	10
4.00x450	1/16"X18"	100-140	2	10
5.00x450	5/32"X18"	130-180	2	10

Customer packing on request.