

ROWELD- 309L

EXTRA LOW CARBON 23CR/12NI TYPE STAINLESS
STEEL ELECTRODE

BASIC ALLOY: MN, CR, NI
AWS/SFA-5.4: E 309L-16
EN ISO-3581-A E 23 12 LR 32

KEY FEATURES:

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.

APPLICATIONS

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

RE-DRY CONDITION:

- Re-Dry the electrode at 250°C for one hour before use.

CHEMICAL COMPOSITION:

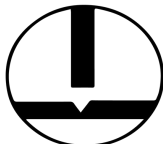
C	Mn	Si	S	P	Cr	Ni
0.04 max.	0.50-2.50	1.00 Max	0.030 Max	0.040 Max	22.00-25.00	12.00-14.00

MECHANICAL PROPERTIES:

UTS (N/mm ²)	EL % (l=5d)	CHARPY "V" NOTCH IMPACT @	FERRITE (FN)
520-660	35-45	+2C : 60-100 J	8-14

WELDING POSITION

1G/1F



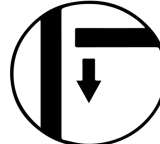
2G/2F



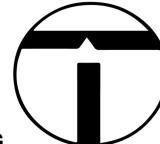
3G UP



3G DOWN



4G



DIEMENSION, CURRENT CONDITION & PACKING DATA

Size (mm) (Dia)	Size (inch) (Dia)	Current Condition (DC+ / AC) Amps	Kg/pkt.	Kg/Case
2.50 / 2.40	3 / 32"	50-80	2	10
3.15 / 3.20	1 / 8"	75-100	2	10
4.00	5 / 32"	110-140	2	10
5.00	3 / 16"	150-180	2	10