

ESAB 309Cb



A basic type, stainless steel electrode depositing a 23 Cr/12 Ni, Cb Stabilised type weldmetal



Classification AWS A 5.4: E 309 Cb-15
 IS 5206: E 23.12 Cb B 20
 DIN 8556: E 23 12 Cb B 20

DESCRIPTION

ESAB 309Cb is a basic coated stainless steel electrode giving austenitic weld deposit of 23 Cr/12 Ni type containing columbium for immunity against weld decay. The C-Cb ratio is carefully controlled to provide stabilisation against intergranular corrosion and higher strength at elevated temperature service of upto 1100°C in continuous service. ESAB 309Cb welds with a very smooth, quite and stable arc in all positions with very little spatter. The slag system design allows for a fluid but controlled slag and a slag cover that is easily detachable to reveal a shiny, smooth and even weld bead.

WELDING CURRENT: DC +

TYPICAL APPLICATIONS

ESAB 309Cb is especially designed for welding AISI 309, 309 Cb steels and joining of dissimilar steels, stainless steel to mild steel, stainless steel to low alloy steel, for root runs in clad steel joints, surfacing on mild steel to improve wear resistance, building up on worn parts of wear resisting steels.

TYPICAL ALL WELDMETAL PROPERTIES

Chemical Composition (%)				Mechanical Properties	
C	0.06	Ni	13.00	UTS	620 N/mm ²
Mn	0.90	Nb	0.85	YS	420 N/mm ²
Cr	23.00	Si	0.70	EL (L=4d)	35%
S	0.015	P	0.020		

CURRENT RANGE & PACKING DATA

Size (mm)	Length (mm)	Current Range (Amps)	No. of Electrodes in a	
			Carton	Cardboard box
2.50	350	40-70	80	400
3.15	350	80-100	65	325
4.00	350	100-150	40	200
5.00	350	140-180	30	150

PACKING: Electrodes are packed in heat sealed plastic cartons and five of these cartons are shrink wrapped in a cardboard box.