

A basic 23/12-type stainless steel electrode

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



DESCRIPTION

ESAB 309 is a basic, all position electrode depositing a 25/12-type weldmetal which is extremely resistant to corrosion and oxidation at elevated temperatures of upto 1100°C. ESAB 309 welds with a very smooth and quite arc in all positions with a very low spatter. The slag is easily detachable and the final weldbead is smooth, finely rippled and shiny. Welds are of radiographic quality.

APPROVALS : RDSO

WELDING CURRENT: DC +

TYPICAL APPLICATIONS

ESAB 309 is specially designed for the welding of AISI 309 type steels, straight chrome steels dissimilar steels for e.g. welding of mild steels to stainless steels, low alloy steel to stainless steels etc. It is also used for surfacing and building up of components to improve its wear resistance.

TYPICAL ALL WELDMETAL PROPERTIES

Chemical Composition (%)				Mechanical Properties	
C	0.08	Ni	13.0	UTS	610 N/mm ²
Mn	1.50	Si	0.40	YS	480 N/mm ²
Cr	23.0	P	0.020	EL (L=4d)	37%
S	0.015				

CURRENT RANGE & PACKING DATA

Size (mm)	Length (mm)	Current Range (Amps)	No. of Electrodes in a	
			Carton	Cardboard box
2.50	350	40-60	80	400
3.15	350	60-90	65	325
4.00	350	85-130	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.