

# ESL'ARC 309



## Classification

Class -

IS-5206: E23.12 R26

AWS -

A5.4 : E309-16

## Applications

Used in applications needing high strength and corrosion resistance at high temperatures upto 1100°C. Suitable for welding of heat resistant chrome steels, AISI 309 Grade of stainless steels. Extensively used in joining dissimilar and also in corrosion resistant surfacing.

## Characteristics

A rutile coated all-position stainless steel electrode that is suitable for welding 23 Cr;12 Ni type austenitic stainless steel and similar grades. The electrode runs on both AC and DC power sources giving smooth ripple-free weld beads and a self-peeling slag. The weld metal has first-rate resistance to corrosion and scaling upto 1100°C.

## Welding Current: DC+, AC 65

5.00x350mm	4.00x350mm	3.15 x 350mm	2.50x350mm
140- 200	100-140	70-110	50-70

## Typical Chemical Analysis :

C%	Mn.%	Si%	Cr	Ni	S%	P%
0.08	0.80	0.70	23.0	12.50	0.02	0.02

## Typical mechanical properties

UTS	YS	Elongation (l=4d)	CVN at RT	Ferrite
600N/mm2	470N/mm2	35%	120 J	5-10



## Shieldarc Equipment Pvt. Ltd.

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