



## STAINLESS STEEL WELDING ELECTRODES

# RASI E 309 - 16

### TECHNICAL SPECIFICATION SHEET



#### CHARACTERISTICS

RASI 309-16 is a medium heavy coated, rutile type all position electrode giving a deposit of 25Cr. 12 Ni. The weld metal has excellent resistance to corrosion and temperature upto 1100oC. Excellent consistency in performance and properties.

#### APPLICATIONS

For Welding of AISI 309, 309L, Mo Straight Chrome Steels and Dissimilar Steels like SS to MS Clad Steel etc.

#### EXCLUSIVE FEATURES

- Spontaneous and quiet arc.
- Extremely low spatter level
- Excellent looking weld bead
- Self Disposal of slag
- Multi positon capability
- Radiographic quality welds

#### CLASSIFICATIONS

IS.5206 : E 23 12 R 26  
AWS / A 5.4 : E 309 - 16

**\*Extra Low Carbon Version is available 309 L - 16 Carbon : 0.04 max  
IS : 5206 E 23.12.LR 26 | AWS / 5.4 : E 309L-16**

storage - Store in warm and dry place. If damped re dry at 300°C for 1 hour.

\*All statements, information and data given are believed to be accurate and reliable but are presented without guarantee, warranty or responsibility of any kind, expressed or implied.

#### CHEMICAL COMPOSITION OF ALL WELD METAL

Carbon - 0.15%	Silicon - 0.90%
Manganese - 0.50 - 2.5%	Sulfur - 0.03%
Phosphorus - 0.04%	Cr - 22 - 25%
Ni - 12 - 14%	

Note: Single Values shown above are maximum

#### MECHANICAL PROPERTIES OF ALL WELD METAL

UTS (MPa) - 550 Min  
ELONGATION (L=4d) - 30% Min.

#### WELDING CURRENT : AC, DC(±)

Ø 2.00 mm - 35 - 45 Amps  
 Ø 2.50 mm - 50 - 75 Amps  
 Ø 3.15 mm - 80 - 100 Amps  
 Ø 4.00 mm - 110 - 140 Amps

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