

**Classifications**

AWS A5.4-06	: E309-16
KS D 7014	: E309-16
JIS Z 3221	: ES309-16

**Description**

- Covering is lime titania type for welding of 22%Cr-12%Ni stainless steel and heat-resisting castings, clad side of type 304 clad steels. Welding of dissimilar steels such as Cr-Mo steel or carbon steel to stainless steel.
- As the deposited weld metal contains ferrite in austenitic structure, its crack resistance is good.
- Good heat resistance and corrosion resistance.
- Redry the electrode at 250~350°C for 30~60 minutes prior to use.

**Welding positions****Typical chemical composition of all-weld metal (%)**

C	Si	Mn	P	S	Ni	Cr	Mo	Cu
0.06	0.72	1.36	0.028	0.012	12.61	23.63	0.20	0.30

**Typical mechanical properties of all-weld metal**

	Y.S (0.2%OS) (MPa)	T.S (MPa)	El. (%)	Remarks
AWS A5.4		min. 550	min. 30	
JIS Z 3221		min. 550	min. 25	
Example	490	610	38	AW
* AW : As-Welded				

**Sizes available and recommended currents (AC or DC +)**

Dia.	(mm)	2.0	2.6	3.2	4.0	5.0
Length	(mm)	250	300	350	350	350
Amp. (A)	F V · OH	40~50 35~45	50~80 45~60	80~110 70~90	110~150 90~130	140~180 -

**Approvals**

ABS	BV	DNV	GL	KR	LR
E309-16	UP	309	4332	RD309	SS/CMn m

\* Others : CWB