

S-309.16N

Type : Rutile

Conformances

AWS A5.4/ ASME SFA5.4 E309-16
 JIS Z3221 ES309-16
 EN ISO 3581-A-E 23 12 R
 KR RD309
 ABS AWS A5.4 E309-16
 LR SS/CMn
 DNV-GL NV 309

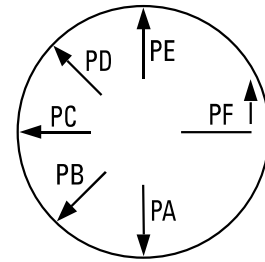
Applications

- Welding of dissimilar steels

Features

- Good resistance to heat and corrosion
- Easy to remove slag
- Low spatter

Welding Position



Current

AC or DC ±

Redrying Conditions

350°C (662°F) X 1hr

Diameter / Packaging

Diameter mm (in)	Length mm (in)	P.V.C	
		packet 2.5kg(5.5lbs)	carton 10kg(22lbs)
2.6 (3/32)	350 (14)		✓
3.2 (1/8)	350 (14)		✓
4.0 (5/32)	400 (16)		✓
5.0 (3/16)	400 (16)		✓
6.0 (15/64)	450 (18)		✓

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Ni	Mo
0.03	0.79	1.10	0.025	0.016	23.4	12.5	0.10

Typical Mechanical Properties of All-Weld Metal

TS MPa(lbs/in ²)	EL (%)
579 (84,100)	38.6

Typical Welding Parameters / Amp.(A)

Diameter mm (in)	2.0 (5/64)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)
Length mm (in)	300 (12)	300 (12)	350 (14)	350 (14)	350 (14)
F & HF	25~55	50~85	70~115	95~145	135~180
V-up, OH	20~50	45~80	65~110	85~135	-