

Shielded Metal Arc Welding

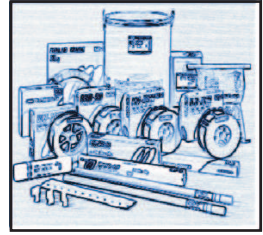
ANU BOND - 309 Cb (E309 Cb - 16)

AWS: SFA 5.4, E 309 cb - 16, IS:5206,23.12 Nb R 26

Stainless Steel Welding Electrodes

Application :

Suitable for joining columbium stabilized stainless steel to high alloy & unalloyed steels, for welding AISI 309-cb type steels, straight chrome steel, Joining stainless steel to low alloy steel and carbon steel.



Characteristics :

A medium heavy Coated rutile type all position electrode yielding 25 Cr, 12 Ni columbium stabilized weld deposit. The addition of columbium provides resistance to intergranular corrosion and high strength at elevated temp service. The weld deposit withstand up to 1100 °C in continuous service. It gives stable arc, low spatter, smooth weld bead with easily removable slag. Redry the electrode at 250 °C for one hour for better result.

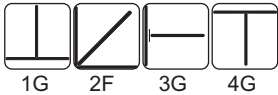
Chemical composition of All-Weld metal (%) as per AWS

C	Mn	Si	P	S	Cr	Ni	Mo	Cb
0.12 Max	0.50- 2.50 Max	1.00 Max	0.040 Max	0.030 Max	22.0-25.0	12.0-14.0	0.75Max	0.70-1.0

Mechanical properties of all-weld metal as per AWS

UTS (N/mm ²)	Elongation (L=4d) %
550 Min	30.0% Min

Welding Positions



Packaging & Welding Current

SIZE (mm)	Kg / Packet	Kg. Per Carton	Current (Amps)	In Amps
2.50 x 350	2	12	AC/ DC (+)	50-80
3.15 x 350	2	12		80-110
4.00 x 350	2	12		110-140
5.00 x 350	2	12		140-180

