



# SS 309 Cb

## STAINLESS STEEL ELECTRODE

**CLASSIFICATION :**

IS : 5206-83 : E 23.12 Nb R26  
AWS/A 5.4 : E 309Cb-16

**CHARACTERISTICS :**

A rutile type stainless steel electrode suitable for welding stainless steels of similar composition in wrought or cast form. The weld metal has excellent resistance to corrosion and temperature upto 1100°C. Presence of columbium provides stabilisation against intergranular corrosion. Operates equally well on AC and DC(+) in all conventional positions.

**APPLICATIONS :**

- \* Welding of dissimilar steels such as 18/8 or 18/8Cb steel to mild steel
- \* Welding the clad side of 18/8 or 18/8 Cb steels.
- \* Applying sheet lining of 12% Cr steel to mild steel shells and hoppers.

**RECOMMENDATIONS :**

To obtain best results redry the electrodes at 200°C for one hour. Use short arc, lower currents and stringer bead technique. Maintain proper interpass temperature in case of dissimilar welding.

**CHEMICAL ANALYSIS OF WELD-METAL(%) :**

C	Mn	Si	Cr	Ni	Cb	S	P	Cu
0.10	0.5-2.5	1.0	22-25	12-14	0.7-1.0	0.03	0.04	0.75
max		max				max	max	max

**MECHANICAL PROPERTIES OF ALL WELD-METAL (AS PER AWS/A 5.4) :**

Ultimate Tensile Strength	Elongation (GL=4d) (%)	CVN Impact Value at 27°C
N/mm <sup>2</sup>		Joules
550 min	30 min	70 min

**CURRENT CONDITIONS : USE AC OR DC (+)**

Size (mm)	2.5x350	3.15x350	4.0x350	5.0x350
Amps	60-80	80-110	110-140	150-180

**SPECIAL CHARACTERISTICS :**

DELTA FERRITE : 5 FN min

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