

PRODUCT INFORMATION

SIFChrome 309L

EN ISO 3581-A: E 23 12 L R 12
AWS: E309L-16

DESCRIPTION

A rutile coated MMA electrode for welding corrosion resistant and heat resistant CrNi steels, joining dissimilar metals and buffering. Suitable for clad steels and provides good cracking resistance.

WELDING POSITIONS



Suitable for use in fillet, downhand, vertical up and overhead positions, in DCEP or AC current modes.

TYPICAL WELD METAL COMPOSITION

C	0.02
Cr	23.2
Mn	0.8
Ni	12.5
Si	0.7
P	0.030
S	0.030

TYPICAL MECHANICAL PROPERTIES

Ult Tensile Strength	550 N/mm ²
Yield Strength	400 N/mm ²
Impact Values ISO-V	47J @ +20°C 32J @ -60°C
Elongation	30%

MATERIAL TO BE WELDED

Typical applications include joining high-strength steels, un-alloyed and low-alloyed heat-treatable steels, as well as stainless or ferritic chromium and austenitic chrome-nickel steels, often where dissimilar compatibility is required.

Commonly used in repair and maintenance applications, but also widely in the power generation sector, general fabrication and construction, and in the process industries.

AVAILABLE FORMATS

STAINLESS STEEL ELECTRODES			
Dia	4kg canister	Length	Current
2.5mm	RC3092540	300mm	60 – 80 A
3.2mm	RC3093240	300mm	80 – 110 A
4.0mm	RC3094040	300mm	100 – 140 A

Current :	AC, DC =+
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For further information, contact Weldability | Sif technical support on **0870 330 7757** or email service@weldability-sif.com



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