

selectarc **Inox 309HB**

Basic type Stainless steel Electrode



Classification

AWS A5.4 : E 309H-15

ISO 3581-A : E 23 12 H B 42

Description & Applications

High carbon basic coated electrode 23% Cr - 12% Ni type stainless steel with about 6 FN delta ferrite. These electrodes are used for welding 24 Cr- 12 Ni wrought and cast stainless steels used for corrosion and oxidation resistant applications at elevated temperatures. Stable arc, good slag removal, regular weld beads.

Base materials

Stainless steels to construction steels:

UNS	Alloy	EN	Material N°
S30900	309	X15CrNiSi 20-12	1.4828
		X12CrNi22-12	1.4829
S30909	309H		

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Fe	Ferrite
0.07	0.4	1.5	22.4	12.6	Rem.	~ 6 FN

All Weld Metal Mechanical Properties

$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)
490	620	33

Welding Current & Instructions

Electrode	$\varnothing \times L$ (mm)	2,5x300	3,2x350	4,0x350	5x450
Current	(A)	70	100	135	180

Redrying 1h at 250°C. Interpass temperature: <200°C.



1G/PA



2F/PB



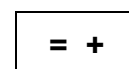
2G/PC



3G/PF



4G/PE



Ind.10

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