

selectarc

Inox 309NbB

**Stainless Steel Electrode
Niobium - stabilised**


FSH WELDING GROUP
INNOVATIVE WELDING CONSUMABLES
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Classification

AWS A5.4 : E309Cb-15
ISO 3581-A : E 23 12 Nb B 42

EN 1600 : E 23 12 Nb B 42

Description & Applications

Basic coated Niobium / columbium stabilised electrode 23 %Cr-12 %Ni type stainless steel, suited to weld Ti or Nb stabilised stainless steels. Mainly used as first layer for cladding, when a final layer 347 (1.4550) is required.

Stable arc, good slag removal, regular weld beads.

Base materials

Construction steels ; Cr-Mo creep resistant steels

Stainless steels to construction steels:

UNS	Alloy	EN 10088	Material N°	UGINE
S32100	321	X6CrNiTi18-10	1.4541	UGINOX 18-10 T
S34700	347	X6CrNiNb18-10	1.4550	

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Nb (Cb)
0.03	0.4	1.2	22.8	12.3	0.75

All Weld Metal Mechanical Properties (typical values as welded)

R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)
500	640	33

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x300	3,2x350	4,0x350	5,0x450
Current	(A)	70	95	130	180

Redrying: 1h at 250°C. Interpass temperature : < 20 0°C.



1G/PA



2F/PB



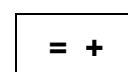
2G/PC



3G/PF



4G/PE



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