



STAINLESS STEEL WELDING ELECTRODES

RASI E 309Mo-16

TECHNICAL SPECIFICATION SHEET



CHARACTERISTICS

RASI 309 Mo -16 is an all positional, rutile type Electrode, which nominal composition of 25Cr, 12 Ni, 2.5 Mo with excellent resistance to Chemical Corrosion. Excellent consistency in performance and properties.

APPLICATIONS

AISI 309Mo with Carbon steels, Low alloy steels, High Tensile Low alloy steels, Mild Steels, Manganese steels etc. and Welding to clad steel of AISI 309Mo grade stainless steels.

EXCLUSIVE FEATURES

Magnificent soft arc with Extremely low spatter & Smoke
Smooth, bright and well rippled beads
Radiographics quality welds
Instant arc strike and restrike with Self detaching slag
Excellent Mechanical properties.

CLASSIFICATIONS

IS.5206 : E 23 12.2 R 26
AWS / A 5.4 : E 309Mo - 16

**Extra Low Carbon Version is also available 309 MoL - 16 Carbon : 0.04 max
IS : 5206 E 23.12.2 LR 26, AWS A/SFA 5.4 : E 309LMo-16**

storage - Store in warm and dry place. If damped re dry at 300°C for 1 hour.

*All statements, information and data given are believed to be accurate and reliable but are presented without guarantee, warranty or responsibility of any kind, expressed or implied.

CHEMICAL COMPOSITION OF ALL WELD METAL

Carbon - 0.12%	Silicon - 0.90%
Manganese - 0.50 - 2.5%	Sulfur - 0.03%
Phosphorus - 0.04%	Cr - 22 - 25%
Ni - 12 - 14%	Mo - 2 - 3 %

Note: Single Values shown above are maximum

MECHANICAL PROPERTIES OF ALL WELD METAL

UTS (MPa) - 550 Min
ELONGATION (L=4d) - 30% Min.

WELDING CURRENT : AC, DC(±)

Ø 2.00 mm - 35 - 45 Amps
Ø 2.50 mm - 50 - 75 Amps
Ø 3.15 mm - 80 - 100 Amps
Ø 4.00 mm - 110 - 140 Amps

***FOR APPROVALS AND CERTIFICATIONS KINDLY CONTACT :-
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