

Standards

TS EN ISO 3581-B	: ES309-16
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AWS A5.4	: E 309 H-16

**Chemical Composition of
Weld Metal % (Typical)**

C	Si	Mn	Ni	Cr
0.06	0.8	0.8	12.0	23.0

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/+20°C)	Elongation (L ₀ =5d ₀) (%)
min. 440	550 - 720	min.47 J	min. 30

Typical Base Material Grades

- Alloyed and unalloyed steels, AISI 309 Type Steel, Tool Steels, Austenitic Cr-Ni and Mn steels

Features and Applications

- Electrode with rutile coating on alloyed core-wire
- Applicability in welding similar/dissimilartype austenitic stainless steels, high-strength unalloyed and heat treatable steels, ferritic Cr and austenitic CrNi steels, austenitic Mn steels
- It provides higher tensile and creep strength at elevated temperatures according to ELOX R 309 L
- Usability in welding at all positions except for vertical downward position

Welding Positions

Current Type

D.C.(+) / A.C.

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010102197	2.50 x 250	3/32 x 10"	50-85	1550
3010102198	3.20 x 350	1/8 x 14"	80-120	3600

Approvals: SEPRO