MODI SS-309L

Classification:
AWS A/ 5.4 : E309L-16

Description:

MODI SS- 309L is a rutile type stainless steel electrode depositing 23 Cr-12 Ni with an extra low carbon, which has excellent corrosion and oxidation resistance in continuous service up to 1100 ^{o}C. Suitable for welding of AISI 309L steels & for joining stainless steel to mild steel.

Applications:

- Welding of AISI 309, 309L type steels.
- Dissimilar joints between stainless steels and low alloy or carbon steels.
- For buffer layer on low alloy and carbon steels.
- Joining corrosion resistant clad steels.

Chemical Composition of Weld Metal (WT. %):

C	Mn	Si	S	P	Ni	Cr	Mo	Cu
0.04 Max	0.50 - 2.50	1.00 Max	0.030 Max	0.040 Max	12.0 - 14.0	22.0 - 25.0	0.75 Max	0.75 Max

Mechanical Properties of Weld Metal:

Tensile Strength (N/mm^2)	Elongation L=4d (%)
520 Min	30 Min

Current Conditions: AC (70 V) / DC (+)

Size (mm)	2.50 X 350	3.15 X 350	4.00 X 350	5.00 X 350
Current (Amps)	50 - 80	80 - 110	110 - 150	150 - 180

Welding Positions: F, H, V-up, OH

Recommendation:

Re-dry the electrodes at 250^{0}C for 1 hour. Keep the re-dried electrodes in holding oven before use (70 to 100^{0}C). Use electrodes within recommended current conditions for better performance.

Caution:

Protect yourself and others. Fumes & gases can be dangerous to heath. Arc rays can injure eyes and burn skin. Electric shock can kill. Refer American National Standard Z49.1 “Safety in welding and cutting”.

Regd. Office: 813, Modi Tower, 98 Nehru Place, New Delhi – 110 019, India, Telephone: 011-42504577
Email: mhi@gmmarc.com

Works: Behind Dayawati Modi Academy, Meerut Muzaffarnagar Road, Modipuram, UP – 250 110, India,
website: www.gmmarc.com