

For Dissimilar Metal such as SUS316L type Stainless Steel and Mild Steel

APPLICATIONS

Welding of clad side of SUS316L class clad steel.

Welding of dissimilar metal such as SUS316L type stainless steel.

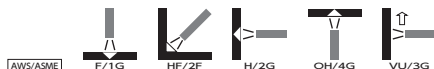
CHARACTERISTICS

S-309ML·R is a Low Carbon-23%Cr-13%Ni-2%Mo covered electrode

GUIDELINES FOR USAGE

1. Welding is operated in either AC or DC electrode positive polarity.
2. Electrodes should be dried at 150~250°C for 60 minutes before use.
3. Dirt such as oil, grease and dust should be completely removed from groove.
4. Preheat is not necessary, interpass temperature should be less than 150°C
5. Excessively wide weaving may cause welding defects. Keep weaving width to less than 2.5 times electrode diameter. Arc length should be kept as short as possible.

WELDING POSITION



■ TYPICAL CHEMICAL COMPOSITION OF WELD METAL (%)

C	Si	Mn	P	S	Ni	Cr	Mo	Other
0.03	0.32	1.80	0.024	0.013	13.2	22.7	2.40	—

■ TYPICAL MECHANICAL PROPERTIES OF WELD METAL

Tensile Strength, MPa	Elongation, %
600	34

■ SIZES & RECOMMENDED CURRENT RANGE<AC or DC(+)>

Diameter (mm)		2.6	3.2	4.0	5.0
Length (mm)		300	350	350	350
Current A	F / H-fillet	55~70	80~100	110~140	140~170
	V-up, OH	45~60	70~80	100~130	—

Indentification color : End-Silver, secondary-red