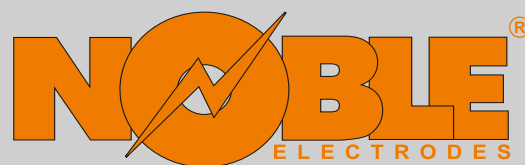


NOBLE - 309

Stainless Steel Electrodes



CLASSIFICATION

AWS - A5.4: E309-16

Characteristics : **NOBLE - 309** is a heavy coated, Rutile type all-positional except vertical downward electrode giving 23-12 deposit which has excellent corrosion and oxidation resistance in continuous service up to 1100°C. It gives a quiet and stable arc, low spatter, smooth weld bead and easily detachable slag. Welds are radiographic sound.

Applications : **NOBLE - 309** is suitable for the welding of stainless steel types 309, straight chrome steels and joining stainless steel to lower alloy steels. It is also suitable for building up mild steel to improve wear resistance and for building up worn parts of wear resisting steels.

Mechanical Properties

Mechanical Tests	AWS Specifications
Tensile Strength	550 N/mm ² (Min.)
Elongation	30 % (Min.)

* If Moist: Re-dry at 250°C For 1 Hr.

Weld Metal Chemistry (%)

Elements	C	Mn	Si	P	S	Ni	Cr	Mo
Range	0.15 Max	2.5 Max	0.90 Max	0.04 Max	0.03 Max	11 - 15	22 - 26	0.5 Max

Packing Specifications & Current Condition

Size (mm)	Pkts. / Case	Wt. / Pkt	Current (Amp.) AC (70V) DC (+)
2.50 x 350	05	2 Kg.	65 - 90
3.15 x 350	05	2 Kg.	80 - 100
4.00 x 350	05	2 Kg.	100 - 135
5.00 x 350	05	2 Kg.	135 - 180

“Noble – Characterized by all Excellent Qualities”