MIDALLOY CHROMAX E309-16/E309H-16 COATED ELECTRODE

CLASSIFICATION

- AWS 5.4 Class E309-16/E309H-16 / ASME SFA 5.4 Class E309-16/E309H-16 / ASME Sec. IX, F4, A9

DESCRIPTION

- MIDALLOY CHROMAX E309-16/E309H-16 is AC-DC titania coated electrode
- Carbon content value is controlled to .04% to .12% for high temperature service.

APPLICATION

- For welding or repairing alloy AISI 309 l
- Dissimilar metal combinations of carbon and low alloy steels to stainless steels.

TYPICAL CHEMISTRY

C	Cr	Ni	Mo	Mn	Si	P	S	Cu	N
.08	23.5	12.3	.10	1.7	.50	.020	.010	.10	.06

FERRITE CONTENT 8-18 WRC 1992

TYPICAL MECHANICAL PROPERTIES

TENSILE STRENGTH	87,500 PSI
YIELD STRENGTH	59,500 PSI
ELONGATION IN 2”	35%

RECOMMENDED WELDING PARAMETERS

DIAMETER	AMPERAGE	
	FLAT	VERTICAL & OVERHEAD
3/32”	70-85	65-75
1/8”	85-110	80-90
5/32”	110-140	100-120
3/16”	120-160	110-130

STANDARD PACKAGING

- 3/32” - 8 lb. can, 48 lb. Carton
- 1/8”, 5/32”, 3/16” - 10 lb. Can, 60 lb. Carton

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