

ROYAL 309Cb (BASIC) (AWS:SFA 5.4, E 309 Cb - 15)

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Applications

Suitable for joining columbium stabilized stainless steel to high alloy & unalloyed steels, for welding AISI 309 – cb type steels, straight chrome steels, Joining stainless steel to low alloy steel and carbon steel.

Characteristics on Usage

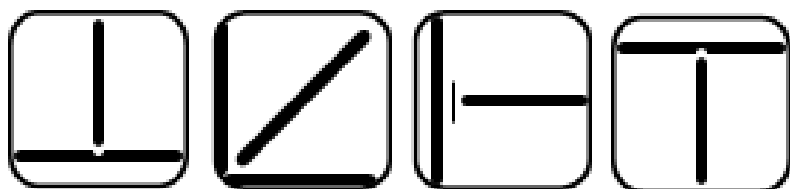
A medium heavy coated rutile type all position electrode yielding 25 Cr, 12 Ni Columbium stabilized weld deposit. The addition of columbium provides resistance to intergranular corrosion and high strength at elevated temp service. The weld deposit withstand up to 1100 oC in continuous service. It gives stable arc, low spatter, smooth weld bead with easily removable slag. Redry the electrode at 250 °C for 1 hour for better result

Notes On Usage

1) Dry the electrodes at 350°C for 60 minute before use

2) Keep the arc as short as possible.

3) Remove rust,water,oil,paint etc. from growe

Welding Positions

1G

2F

3G

4G

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo
0.12 Max	0.50-2.50	1.0 Max	0.030 Max	0.040 Max	22.0-25.0	12.0-14.0	0.75

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	ELONGATION (L = 4d) %
550 Min	30 % Min

Packing and Welding Current

SIZE (mm)	KG PER PACKET	KG PER CARTON	Current (Amps)	In Amps
2.50X350	2	10	AC/DC (+)	50-80
3.15X350	2	10		80 - 110
4.00 x 350	2	10		110 - 140
5.00 x 350	2	10		140-180

Packing

Vaccum packing