

SUPRANOX RS 309L

MMA Electrodes Stainless and Heat resistant steels

Semi-basic MMA electrode suitable for the welding of stainless steels containing 22-25% Cr and 12-14% Ni (AISI 309; AISI 309L).

Particularly suitable for the welding of dissimilar steels. Service temperature +1000°C. Excellent weldability with a spatter free arc, self-releasing slag combined with a very smooth bead appearance. Efficiency 100%.

Packed in Gaspack system.

Classification	
AWS	A5.4: E 309L-16
EN	1600: E 23 12L R 12
GOST	10052-75: Э10Х25Н13Г2 similar

Approvals	Grades
TÜV	

see Appendix, Classification Society Approvals, for details pag. 521

Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Cu	N	Ferrite
0.03	0.75	0.70	≤ 0.025	≤ 0.030	23	12	-	-	-	-	8-13

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) -20°C	Hardness
As Welded	≥ 320	≥ 520	≥ 30	≥ 47	-

Materials

A312 TP309S; carbon steel to stainless steels joint

Storage and redrying

Keep dry and avoid condensation.

Re-drying not generally required.

If necessary: 350-370 °C for 1 hour, 3 times max.

Current condition and welding position

AC; DC+



Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
2,0	300	30-50	11,8	7,0
2,5	300	45-70	19,3	11,6
3,2	350	65-120	36,2	21,6
4,0	350	115-140	54,1	32,4
5,0	350	130-180	86,6	52,0