

# TASETO Welding Materials

Stainless Steel Electrodes

For Shielded Metal Arc Welding

## RNY309L

### ● Applicable Specification

JIS Z 3221 ES309L-16

AWS A5.4 E309L-16

### ● Identification Color

End Face: Yellowish Green

Side Face: —

### ● Applications and Characteristics

TASETO RNY309L is the low carbon type electrode of RNY309 and is suitable for first layer of low carbon type stainless steel overlay welding. Also, this electrode provides the performance as equal as RNY309 when used in welding of dissimilar metals and in welding of martensitic and ferritic type stainless steel such as Type 410 or 430.

RNY309L is a lime-titania type electrode suitable for positional welding.

### ● Notes on Usage

\* Dry the electrode at 150°C to 200°C for 60 minutes before use.

\* Remove oil and dust from the surface to be welded.

### ● Chemical Composition of All Weld Metal (%)

	C	Si	Mn	P	S	Ni	Cr	Mo	Cu
Typical	0.030	0.47	1.81	0.022	0.006	13.45	23.59	0.35	0.13

### ● Mechanical Properties of All Weld Metal

	Tensile Strength (MPa)	5D Elongation (%)	Absorbed Energy at 20°C (J)
Typical	551	41.0	106

### ● Other Properties of All Weld Metal

\* Typical Ferrite Content : 8.3% (Schaeffler's Diagram)

### ● Sizes Available, Recommended Welding Currents (AC or DCEP)

Size (mm)	Length (mm)	Welding Current (A)	
		Flat	Vertical, Overhead
2.6	300	50~90	45~80
3.2	350	80~120	65~110
4.0	350	110~150	85~135
5.0	350	150~200	—