

# TASETO Welding Materials

Stainless Steel Electrodes

For Shielded Metal Arc Welding

## RNY309

### ● Applicable Specification

JIS Z 3221 ES309-16

AWS A5.4 E309-16

### ● Identification Color

End Face: Black

Side Face: —

### ● Applications and Characteristics

TASETO RNY309 is designed to increase the ferrite content in its all weld metal, so it is mainly used for welding of dissimilar metals joint such as stainless steel to mild steel or to low alloy steel and the first layer of overlay welding to carbon steel or low alloy steel.

RNY309 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	0.065	0.47	1.70	0.025	0.006	13.61	24.50	0.18	0.12

### ● Mechanical Properties of All Weld Metal

	Tensile Strength (MPa)	5D Elongation (%)
Typical	597	40.4

### ● Other Properties of All Weld Metal

\* Typical Ferrite Content : 7.7% (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	—