



M-90 E309

FEATURES

- *GOOD RESISTANCE TO HEAT AND CORROSION
- *EASY TO REMOVE SLAG
- *LOW SPATTER

APPLICATION

- *Rutile-basic coated low carbon all positions stainless steel electrode.
- *Suitable for welding high alloyed corrosion resistant Cr-Ni-Mo steels, dissimilar steels (austenitic to ferritic steels).
Deposition of austenitic cladding root runs.
- *Focused and stable arc.
- *Easy slag release.

CLASSIFICATION

- *A5.4/ ASME SFA5.4 E309.16

CHEMICAL COMPOSITIONS

C	Si	Mn	P	S	CR	Ni	MO
0.03	0.79	1.1	0.025	0.016	23.4	12.5	0.1

MECHANICAL PROPERTIES

T.S	EL
N/mm2 (lbs/in 2)	(%)
579 (84,100)	38.6

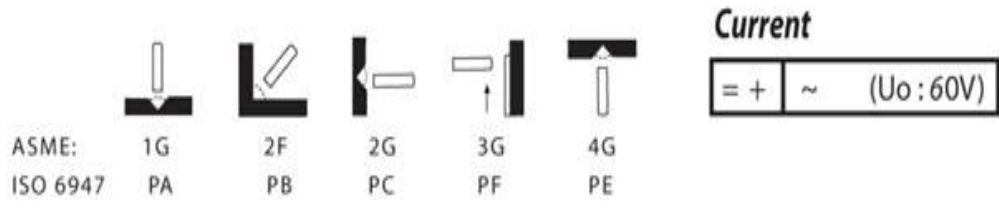
WELDING PARAMETERS

DIAMETER (mm)	2.5	3.2
LENGTH (mm)	350	350
CURRENT (amps)	50-85	70-100

CURRENT

- *AC or DC +/-

WELDING POSITIONS



FOR STAINLESS STEEL