

AROSTA 309H

MMA (SMAW)

STAINLESS STEEL ELECTRODE

PRODUCT DESCRIPTION

A rutile basic all position stainless steel electrode
Specially developed for high temperature applications like industrial furnaces (ovens)
High resistance to oxidation up to 1050°C
Weldable on AC and DC

ASME IX QUALIFICATION

QW432	F-No 5
QW442	A-No 8
Mat-Nr	1.4829

CLASSIFICATIONS

AWS A5.4M	E309H-16*
ISO 3581	E 23 12 R 3 2*

TEMPERATURE RANGE

Pressurized parts	-10...+400°C
Oxidation resistance	to 1100°C

WELDING POSITIONS (ISO/ASME)



PA/1G



PB/2F



PC/2G



PF/3Gu



PE/4G



PH/5Gu

CURRENT TYPE

AC/DC +/-

CHEMICAL COMPOSITION (WELD METAL WT %)

	C	Mn	Si	Cr	Ni	FN
Min.	--	--	--	20.0	10.0	--
Max.	0.15	2.5	1.2	23.0	13.0	--
Typical	0.10	0.8	1.6	22.0	11.0	3.8

ALL-WELD MECHANICAL PROPERTIES

As welded	AWS A5.4	ISO 3581-A	Typical
Tensile strength [MPa]	min. 550	min. 550	700
0.2% proof strength [MPa]	--	min. 350	500
Elongation [%]	30	25	30
Impact ISO-V(J) +20°C	--	--	50

TYPICAL OPERATING PARAMETERS, DC +VE ONLY

Diameter (mm)	2.5	3.2
min. A	40	60
max. A	110	120

PACKAGING DATA

	Diameter (mm)	Length (mm)	Item number	No of pieces		Weight (kg)	
				pack	box	pack	box
CARDBOARD BOX	2.5	350	528312	120	600	2.6	13.5
	3.2	350	528329	130	390	4.8	14.9

All information in this data sheet is accurate to the best of our knowledge at the time of printing. Please refer to www.specialalloys.eu for any updated information.