



## D&H 309 H

**CODIFICATION :** AWS : SFA 5.4 E309H-16

### CHARACTERISTICS AND APPLICATIONS :

Electrodes produce highly crack resistant weld metal having good resistance to corrosion, oxidation and high temperature up to 1100°C. It is ideally suited for welding similar alloys in wrought or cast form. It can also be used for welding dissimilar metals, such as joining SS304H to carbon steel, welding the clad side of SS304H clad steels, and applying stainless steel sheet lining to carbon steel shells.

### TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL :

Element :	C	Mn	Si	S	P	Cr	Ni
Percent :	0.080	1.60	0.40	0.015	0.018	23.5	12.5

### TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL :

UTS (MPa)	Elongation (L = 4d)%
610	32.0

### CURRENT AND PACKING DATA : AC / DC(+)

Size (mm)	: 5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range (Amps)	: 150-180	110-140	80-110	60-80
Weight/Cartron (kgs)	: 2.5	2.5	2.5	2.5

### PRECAUTIONS :

- 1 The electrodes should be dry. In case of moisture pick-up re-dry the electrodes at 250-300°C for one hour.
- 2 Use lowest size of electrode possible and low current.
- 3 Use short arc.