CHS302

Stainless Steel Covered Welding Rod

AWS A5.4 E309-16
ISO 3581-A-E (22 12) R 3 2
ISO 3581-B-ES309-16
BS EN 1600-E 22 12 R 3 2
CSA W48 E309-16
JIS Z3221 D309-16
GB/T 983 E309-16

Type of Covering: Lime-titania
Welding Position: F, H, HF, OH, V
Type of Current: DCEP or AC

Features & Applications

It is used for welding stainless steel structures fabricated by similar composition stainless steels and for dissimilar steels welding (Cr19Ni10 stainless steel with mild steels) as well as for welding high chrome steels or high manganese steels also. The weld metal has good performance of crack-resisting and oxidation-resisting. Particularly it is suitable for flat welding sheets.

Chemical Composition of Deposited Metal (%)

	C	Mn	Si	Cr	Ni	Mo	Cu	S	P
Standard	≤0.15	0.50-2.50	≤1.00	22.0-25.0	12.0-14.0	≤0.75	≤0.75	≤0.03	≤0.04
Typical	0.064	0.98	0.64	24.34	12.82	0.29	0.20	0.012	0.027

Mechanical Properties of Deposited Metal (AW)

	Tensile Strength Rm (MPa)	Elongation A4 (%)
Standard	≥550	≥30
Typical	595	39

Sizes Pieces & Recommended Current (DC^+ or AC)

Size (mm)		2.0 x 300	2.5 x 300	3.2 x 350	4.0 x 400	5.0 x 400
Current (A)	F	25-50	50-80	80-110	110-160	160-200
	V, OH	25-40	40-65	70-95	95-140	—

Notice: 1) The rod should be baked at 300℃-350℃ for 1 hour before use.

2) The surfaces to be welded must be cleaned away impurities of oil contamination, rust, moisture and so on.

3) Smaller current and short arc are recommended in welding and weave beads no wider than 2.5 times of the diameter of the core rod is better.