

# TASETO Welding Materials

Stainless Steel Electrodes

For Shielded Metal Arc Welding

## RNY309Mo

### ● Applicable Specification

JIS Z 3221 ES309Mo-16  
AWS A5.4 E309Mo-16

### ● Identification Color

End Face: Silver  
Side Face: —

### ● Applications and Characteristics

Major uses of TASETO RNY309Mo are the same as RNY309, dissimilar metal joint welding and overlay welding. Especially, RNY309Mo containing about 2.5%Mo, it is preferred to apply the first layer of Type 316 stainless steel overlay.

RNY309Mo 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	0.060	0.58	1.51	0.021	0.007	13.06	24.06	2.45	0.12

### ● Mechanical Properties of All Weld Metal

	Tensile Strength (MPa)	5D Elongation (%)	Absorbed Energy at 20°C (J)
Typical	650	37.4	82

### ● Typical Mechanical Properties of All Weld Metal in Elevated Temperatures

Temperature (°C)	Tensile Strength (MPa)
550	464
650	384
725	330
800	276

### ● Other Properties of All Weld Metal

\* Typical Ferrite Content : 15.0% (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	—