



# AUSTOMANG 209

STAINLESS STEEL (Austenitic Manganese Steel)

AWS A/SFA 5.4 **E209-16**

### CLASSIFICATION:

ISO 3581-B  
ES209-16

### KEY FEATURES:

- Rutile type electrode
- High strength, toughness and cracking resistance
- Smooth arc characteristics
- Easy slag removal
- Nitrogen strengthened austenitic stainless steel alloy
- All position welding capability
- Radiographic quality weld

**APPROVALS:** CE

### TYPICAL APPLICATIONS:

- Welding of high tensile steels and fine grained steels
- Joining high strength, low alloy or microalloyed steels to themselves or to lower strength steels, including carbon steels



### TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Cr	Ni	Mo	N	V
0.05	5.9	0.7	23	11.1	2.6	0.2	0.2

### MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%
Specification	As Welded	690 min	15 min

### PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A		
2.5 x 350	60-90	 <b>AC (70 OCV) /DCEP</b>  <b>REDRYING CONDITION:</b> 250-300°C for minimum 1 hr.	Flat butt and fillet welds only  
3.15 x 350	100-140		
4.0 x 350	140-180		
4.0 x 350	140-180		
5.0 x 450	190-250		

Available in Standard carton packing of 10 kg box containing 5 cartons of 2 kg each.