

The **XUPER 2240 Welding Electrodes** from **Metals And Welding Specialities** are premium-quality welding electrodes engineered for high-performance applications involving stainless steels and dissimilar joints. Designed to deliver exceptional mechanical properties and corrosion resistance, these electrodes are based on the **AWS A5.4 E309L-16** classification, equivalent to **UNS S30983** and **ASTM Grade 309L**. They provide outstanding fusion between dissimilar metals such as carbon steel and stainless steel, ensuring reliable weld integrity even in demanding service conditions.



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Manufactured with a low-carbon core wire and a specialized rutile coating, the **XUPER 2240** electrode minimizes carbide precipitation and offers superior resistance to intergranular corrosion. Its slag system produces a smooth, uniform bead appearance with easy slag removal, enhancing operator efficiency and weld quality. This electrode demonstrates excellent arc stability and spatter control, making it ideal for use in fabrication, repair, and maintenance welding across a wide range of industrial environments including petrochemical, food processing, and marine applications.



XUPER 2240 Welding Electrodes, XUPER 2240 Welding Electrodes Manufacturers, XUPER 2240 Welding Electrodes Suppliers, XUPER 2240 Welding Electrodes Stockists, XUPER 2240 Welding Electrodes Exporters

The metallurgical structure of the deposited weld metal provides an optimal balance of strength and ductility. With its high chromium and nickel content, the **XUPER 2240** electrode resists oxidation and scaling at elevated temperatures, extending the lifespan of welded components exposed to thermal cycling. It is particularly suitable for joining dissimilar combinations such as 304 to mild steel or welding stainless steel overlays on carbon steel substrates where strength and corrosion resistance are equally critical.

When applied under controlled parameters, **XUPER 2240 Welding Electrodes** ensure low hydrogen diffusion, reducing the risk of cracking and weld defects. The electrode operates efficiently on both AC and DC polarity, offering versatility for manual metal arc (MMA) welding operations in all positions. It meets stringent quality standards for chemical composition and mechanical performance, aligning with global specifications like **UNS S30983** and **ASTM A240 Grade 309L**.



XUPER 2240 Welding Electrodes in India, XUPER 2240 Welding Electrodes Manufacturers in India, XUPER 2240 Welding Electrodes Suppliers in India, XUPER 2240 Welding Electrodes Stockists in India, XUPER 2240 Welding Electrodes Exporters in India

Metals And Welding Specialities upholds the highest standards of manufacturing precision, ensuring that every XUPER 2240 electrode is consistent in performance, arc behavior, and deposition rate. This product is trusted by welding professionals who demand precision, strength, and durability in every weld. Whether used for stainless fabrication, maintenance of process equipment, or joining steels with differing thermal expansion rates, the XUPER 2240 delivers dependable, high-quality results with reduced downtime and improved productivity.

Specification XUPER 2240 Welding Electrodes



Property	Specification
Product	Xuper 2240
Manufacturer	Castolin / Eutectic
Classification (EN / AWS)	DIN EN ISO 1071: E C NiFe-1 · AWS A5.15: ENiFe-CI
Type	Low-heat-input coated electrode for cast irons (Ni-Fe, Cu-alloyed deposit)
Typical deposit composition	Ni-Fe with Cu-alloying (nodular graphite deposit)
Tensile strength (typical)	55,000 psi (≈ 380 N/mm ²)
Yield strength (typical)	38,000 psi (≈ 262 N/mm ²)
Hardness (as deposited)	75 HRB
Welding positions	All positions

Current / Polarity	AC or DCEN (-)
Available diameters	3/32" (2.4 mm), 1/8" (3.2 mm), 5/32" (4.0 mm)
Recommended amperage by diameter	3/32" (2.4 mm): 80–90 A · 1/8" (3.2 mm): 105–115 A · 5/32" (4.0 mm): 130–145 A
Typical applications	Pump casings, bell housings, high-strength alloyed cast iron gear boxes, machine bases, repair of foundry defects, motor casings
Packaging (examples)	Plastic containers: 5.5 lb (3/32"), 11 lb (1/8") (typical packaging options)
Post-weld treatment	Slow cool after welding (use insulating material such as vermiculite or heat-retardant blankets)

Equivalent Grade Of XUPER 2240 Welding Electrodes



Xuper	AWS Classification	EN ISO	DIN Standard	Werkstoff No.	UTP	Böhler	ESAB	Lincoln Electric	Thermanit
XUPER 2240	E2209-16	E 22 9 3 N L R 1 2	E 22 9 3 NL	1.4462	UTP 2205	FOX CN 22/9 N-L	OK 67.50	Blue Max 2209	Thermanit Duplex 2209

XUPER 2240 Welding Electrodes Parameters



Parameter	Value / Range
Current / Polarity	AC / DCEP (+)
Tensile Strength (typical)	88,000 psi (~ 607 MPa)
Hardness (as deposited)	HRB ~ 95
Hardness (after work-hardening)	~ HRC 30
Amperage – A Range (heavy / multipass)	1/8" (3.2 mm): 140 – 180 A 5/32" (4.0 mm): 180 – 250 A
Amperage – B Range (moderate)	1/8" (3.2 mm): 90 – 130 A 5/32" (4.0 mm): 120 – 160 A
Recommended Weave / Technique	Weaving limited to 1½ × electrode diameter
Maximum Preheat / Heat Limit	Do not heat 12 % Mn steel over 400 °F (204 °C)
Typical Hardness (alternative source)	As deposited: HRB 80–90 Work hardened: HRC 28–32

People Also Searched

E309L-16 welding rod, UNS S30983 electrode, ASTM A240 Grade 309L, stainless steel electrodes, 309L filler rod, stainless dissimilar welding rod, 309L-16 arc welding electrodes, 309L stainless stick electrodes, stainless overlay electrode, E309L-16 composition, AWS A5.4 electrode, stainless steel joining electrode, low carbon 309L welding rod, 309L electrode supplier, 309L

filler wire, 309L stainless welding applications, dissimilar metal welding electrodes, stainless repair electrode, 309L stainless steel coating, 309L welding rod polarity, stainless to carbon steel welding, high temperature welding electrodes, 309L low hydrogen electrodes, stainless steel maintenance electrode, 309L welding parameters, stainless welding rod manufacturer, E309L electrode data sheet, corrosion resistant welding electrode, 309L electrode for fabrication, stainless overlay welding rod, AWS E309L-16 specification, 309L electrode mechanical properties, stainless to mild steel electrode, 309L electrode price, 309L electrode density, 309L stainless steel welding electrode, 309L electrode uses.