

Coated Electrode for Stainless Steels

Classification

EN 1600 : E 23 12 2 LR 32
AWS A5.4 : E309MoL-16

General Description

A high Cr-Ni-Mo alloyed all position rutile-basic electrode.
It gives high corrosion resistant deposit.
Weldable on AC and DC (+) polarity.

Chemical Composition (w%), Typical, All Weld Metal

C	Si	Mn	Cr	Ni	Mo
0.03	0.80	0.80	23	12.5	2.7

Mechanical Properties, Typical, All Weld Metal

Yield Strength : 575 N/mm²
Tensile Strength : 720 N/mm²
Elongation (L=5d) : 30 %
Impact (ISO-V) : 60 J (+20°C)

Approvals

GOST, SEPRO

Applications and Materials to be Welded

Specially developed for welding stainless steel to mild steel and root runs in cladding. It is also suitable for repair welding in dissimilar joints and steels difficult to weld. Maximum plate thickness in butt welds is about 12 mm. Build-up welding on mild or low alloyed steels.

	EN 10088-1/-2	EN 10213-4	W. Nr.
First Layer in CrNiMo Claddings	X2 CrNiMo 17 12 2	–	1.4404
	X2 CrNiMo 18 14 3	–	1.4435
	X2 CrNiMoN 17 11 2	–	1.4406
	X2 CrNiMoN 17 13 3	–	1.4429
	X4 CrNiMo 17 12 2	–	1.4401
	X4 CrNiMo 17 13 3	–	1.4436
	X6 CrNiMoTi 17 12 2	–	1.4571
	X10 CrNiMoTi 17 13 3	–	1.4573
	X6 CrNiMoNb 17 12 2	–	1.4580
		G-X5 CrNiMo 19 11	1.4408

Welding Parameters / Packing and Diameter Informations / Welding Positions

Current Type and Polarity : AC min 50 V ; DC (+)

Diameter [mm]	Length [mm]	Current [A]	Electrode Weight [g/100 pcs]	Box Weight [kg] Quantity [pcs/box]	Export Box Box Weight [kg]
2.50	250	60 - 85	1755	1.5 / 90	1.5
3.25	300	90 - 125	3355	2.1 / 63	2.0
4.00	350	125 - 160	5550	2.6 / 45	2.5
5.00	350	150 - 190	8660	2.5 / 29	2.5



1G/PA



2F/PB



2G/PC



4G/PE



3G/PF

Liability : All information in this data sheet is based on the best available knowledge, is subject to change without notice and can only be considered as suitable for general guidance. **Fumes** : Consult information on Welding Safety Sheet, available upon request.