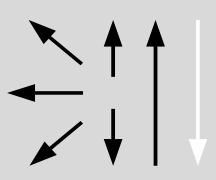


Classification							
<b>AWS A5.4</b>		<b>EN ISO 3581-A</b>			<b>GB/T 983</b>		
E309L-16		E 23 12 L R			E309L-16		
Characteristics and typical fields of application							
23Cr-12Ni stainless steel rutile - coated electrode; with good corrosion resistance below 300 ° C; Electrode designed for dissimilar welding between stainless steel and carbon steel (austenitic / ferrite)							
Base Materials							
Over-alloyed electrode for surfacing unalloyed steel, joint welding non-molybdenum-alloyed stainless steel to unalloyed steel and welding clad material.							
Typical analysis of all weld metal (Wt.-%)							
<b>C</b>	<b>Si</b>	<b>Mn</b>	<b>Cr</b>	<b>Ni</b>	<b>Mo</b>	<b>Cu</b>	<b>N</b>
0,02	0,7	0,80	23,5	12,4	0,05	0,02	0,07
Ferrite Number ≈ 10-15 FN WRC 92							
Mechanical properties of the weld metal							
Heat Treatment	Yield strength	Tensile strength	Elongation	Impact work			
	R <sub>e</sub> N/mm <sup>2</sup>	R <sub>m</sub> N/mm <sup>2</sup>	(L <sub>0</sub> =4d <sub>0</sub> )	ISO-V KV J			
	MPa	MPa	%	+20°C			
As Welded	450 (≥ 320)	560 (≥ 510)	40 (≥ 30)	65(≥40)			
Operating Data							
		<b>Polarity</b> DC (+) / AC	Interpass temperature: Max. 150°C Instruction for Re-drying: Re-dry for 3 h at 250-280°C before using				
Approval							
ABS							
Size, Packing and Recommended welding parameters							
Size (mm)	Kg / Pack		Kg / Box		Amperage (A)		
2.50 x 300	3,63		10,89		50-75		
3.25 x 350	4,10		12,30		60-120		
4.00 x 350	4,10		12,30		110-160		
5.00 x 450	4,54		13,62		150-200		

\* New product name. we confirm that above electrodes name are equal.