selectarc

Inox309LMo

Stainless Electrode for repairing

FSH WELDING GROUP
INNOVATIVE WELDING CONSUMABLES
www.fsh-welding.com

Classification

AWS A5.4 : E309LMo-16
ISO 3581-A: E 23 12 2 LR 32

EN 1600 : E 23 12 2 L R 32

Description & Applications

Low carbon Rutile-basic coated 23% Cr 12% Ni 2% Mo stainless steel type electrode, used to weld on 316L stainless steels and for dissimilar joints between construction / mild steels and stainless steels. Intermediate layer for a 316L type cladding.
Due to its high level of delta ferrite also used as a universal repairing electrode in maintenance welding. Highly crack resistant. Soft fusion, nice aspect of the bead, slag lifts by itself.

Base materials:

Stainless steels for general use:

UNS	Alloy	EN 10088	Material N°	UGINE
S31600	316	X5CrNiMo17-12-2	1.4401	UGINOX 17-10 M
S31603	316L	X2CrNiMo17-12-2	1.4404	UGINOX 18-11 ML
S31635	316Ti	X6CrNiMoTi17-12-2	1.4571	UGINOX 17-11 MT

+ For dissimilar joints, low alloy to stainless steels.

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Mo	Fe
<0.03	0.8	0.7	22.5	12.5	2.3	Rem.

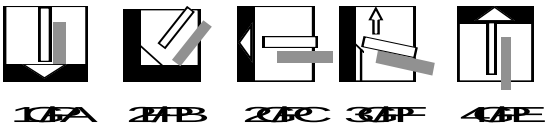
All Weld Metal Mechanical Properties

$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)	KV (J)
>450	>650	>25	+20°C >55 -40°C >45

Welding Current & Instructions

Electrode	ØxL (mm)	2,0x300	2,5x300	3,2x350	4,0x350	5,0x450
Current	(A)	45	70	100	135	180

Redrying 1h at 250°C, if necessary. Interpass temperature: <200°C.



= +	~ 70V

ind.11