UTP S 6824 MoLC

Low carbon stick electrode for dissimilar metal joints and claddings

Classifications	
EN ISO 3581-A	AWS A5.4
E 23 12 2 L R 3 2	E309MoL-17

Characteristics and field of use

Is highly alloyed low carbon electrode corresponding to AWS 5.4 309MoL-17. The electrode is designed for dissimilar welding between stainless and mild or low alloy steels but can also be used for overlay welding, providing an 18 Cr 8 Ni 2 Mo deposit from very first layer. It can also be used for welding high strength steels such as Hardox and Armox.

Base materials

1.4401, 1.4404, 1.4580, 1.4571

Typical analysis of all weld metal (Wt.-%)

C	Si	Mn	Cr	Ni	Mo
0.026	0.90	0.75	22.9	12.9	2.3

Ferrite Number ≈ 20 FN WRC 92

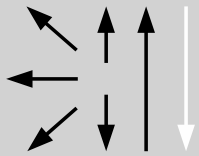
Mechanical properties of the weld metal

Yield strength $R_{P0,2}$	Tensile strength R_m	Elongation A	Impact strength K_V (J)	
MPa	MPa	%	+ 20°C	-60°C
515	645	34	33	21

Welding instruction

Weld area must be thoroughly cleaned and degreased. Preheating and post heat treatment have to be adjusted to the base metal. Re-drying 2 h at 120-200°C.

Welding positions



Current type DC (+) / AC

Approvals

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Size, Packing and Recommended welding parameters

Size mm	Kg / Pack	Kg / Box	Amperage (A)
2.50×350	3.63	10.89	45 - 80
3.25×350	4.10	12.30	70 - 120
4.00×450	5.40	16.20	90 - 160
5.00x450	5.40	16.20	150 - 220

All information provided is based upon careful investigation and intensive research.
However, we do not assume any liability for correctness and information is subject to change without notice.