

Standards :

TS EN ISO 3581 - A	:	E 23 12 LR 32
EN ISO 3581 - A	:	E 23 12 LR 32
AWS A5.4	:	E 309L - 16

**Chemical Composition of Weld Metal-
% (Typical) :**

C	Si	Mn	Ni	Cr
0.03	0.8	0.8	12.6	23.0

Mechanical Properties :

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/+20 °C)	Elongation (L ₀ =5d ₀)(%)
min. 440	540-720	min.47 J	min. 30

Typical Base Material Grades :

- * High-strength unalloyed and heat-treatable steels, ferritic Cr and austenitic CrNi steels, austenitic Mn steels.
- * Unalloyed tempered steels, tool steels, hard manganese steels, ferritic chromium steels, austenitic nickel-chromium steels, hard-to-weld steels.

Features and Applications :

- * Similar-type austenitic stainless steels, dissimilar metals , buffer layers on mild and low-alloy steels prior to build up or overlaying with any stainless electrodes, joining of corrosion resistant stainless steel with mild or low alloy steels, clad steels. * Higher than other austenitics electrodes. * Good crack resistance with hard to weld steels.
- * Higher ferrite % of weld metal is higher than that of other austenitic electrodes.
- * Re-drying : 300 °C / min. 2 h.

Welding Positions :



Current Type :

- D.C.(+)
- A.C.

Operating Data :

Diameter x Length (mm)	Diameter x Length (inch)	Welding Current (A)	Weight g /100 pcs
2.50 x 250	3/32 x 10"	60-90	1570
3.20 x 350	1/8 x 14"	80-120	3720
4.00 x 350	5/32 x 14"	100-160	5175

Approvals :

TSE, CE, BV, ABS, GOST-R, SEPRO