SWP

Stainless Steel Electrode

309L-17

ELOX R 309 L-17

Standards :

TS 2716 EN 1600	:	E 23 12 LR 32
EN 1600	:	E 23 12 LR 32
AWS A5.4	:	E 309L - 17

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 ($L_o=5d_o$)(%)
min. 440	540-720	min.47 J	min. 30

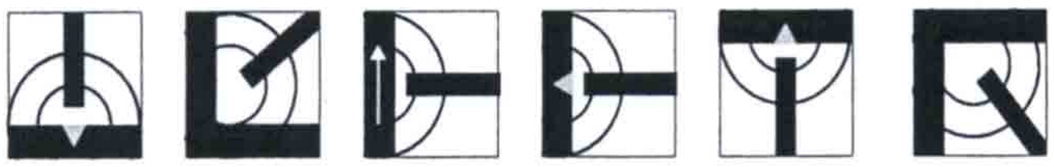
Typical Base Material Grades :

* 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 :

* Rutile-coated low-carbon electrode for use in high-strength unalloyed and heat treatable steels, ferritic Cr and austenitic CrNi steels, austenitic Mn steels.
* Similar-type austenitic stainless steels, dissimilar metals, buffer layers on mild and low-alloyed 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 wity problematic steels.
* Ferrite percentange of weld metal than that of toher austenitic electrodes.
* Requirement of re-drying for minimum 2 hours at the temperatures 300 °C.

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	---
3.20 x 350	1/8 x 14"	80-120	---
4.00 x 350	5/32 x 14"	100-160	---

Approvals :

TSE, CE