

Product Data Sheet

Rutile type Stainless Steel electrode

SUPER OPTIMAL 309L-17

Classification **AWS A 5.4:** E 309L- 17 **DIN EN ISO 3581-A:** E 23 12 LR 12
DIN EN 1600: E 23 12 LR 12 **Werkstoff Nr:** 1.4332

Description and applications Rutile type low carbon MMA electrode for joining dissimilar steels (austenitic to ferritic steels) and for cladding of austenitic steels. Weld metal consists of austenite with approx 15% delta ferrite. Cladding on unalloyed and low-alloy steels are corrosion resistant in the first layer. Good fusion of joint faces, finely rippled bead surface, easy slag removal, excellent arc striking and re-striking. Packed in vac-pack system.

Base materials

Stainless steels for general use and for high temperature applications:				
UNS	Alloy	EN	Material Na	UGINE
S30900	309	X15CrNiSi 20-12	1.4828	UGINOX R20-12
S30453	304LN	X2CrNiN 18-10	1.4311	
S30908	3098	X12CrNi23-13	1.4833	UGINOX R24-13S
		X10CrSiG	1.4712	
		X10CrA1 18	1.4742	

Typical Weld Metal Chemical Composition (%)

C	Si	Mn	Cr	Ni	Mo	S	P
0.03	0.90	0.90	23.80	12.80	0.10	0.012	0.020

All weld metal Mechanical Properties (Typical)

Tensile Strength R_m (N/mm ²)	Elongation A_5 (%)	Charpy Impact value (ISO-V J RT)
600	>35	60

Amperes (A)

2.50mm	3.15mm	4.00mm	5.00mm
50-80	80-120	110-150	150-180

Welding instruction

Keep dry and avoid condensation. Re-dry generally not required, if necessary redry electrodes at 300-350°C for 1hr. Interpass temperature :< 200°C.

Welding Position

1G/PA	2F/PB	2G/PC	3G/PF	4G/PE	

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