

Product Data Sheet

Stainless steel Rutile type electrode

SUPER OPTIMAL 309LMo-17

Classification **AWS A 5.4:** E 309 LMo-17 **DIN EN ISO 3581-A:** E 23 12 2 LR 32
DIN EN 1600: E 23 12 2 LR 32 **Werkstoff Nr:** 1.4459

Description and applications Low carbon Rutile-basic coated 23Cr 12Ni 2Mo stainless steel type electrode, used to weld on AISI 309 & 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 approx 15-25, also used as an universal repairing electrode in maintenance welding. Highly crack resistant. Soft fusion, nice aspect of the bead, slag lifts by itself. Packed in vacpack system.

Base materials **Stainless steels:**
 AISI : 316 L, 316 Ti, 316 Cb, 309, 309 Cb
 Werkstoff Nr : 1.4401, 1.4404, 1.4571
 + for dissimilar joints. low alloy to stainless steels.

**Typical weld metal
Chemical
Composition (%)**

C	Si	Mn	Cr	Ni	Mo	S	P
0.03	0.90	1.00	23.50	13.10	2.50	0.012	0.015

**All weld metal
mechanical
properties
(typical)**

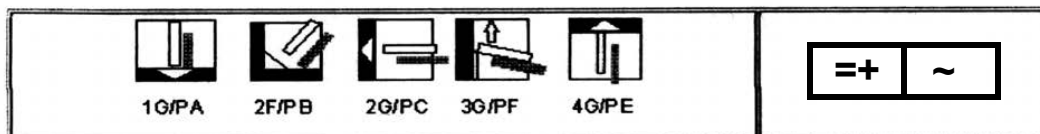
Tensile Strength R_m (N/mm ²)	Elongation A_5 (%)	Charpy Impact value (ISO-V J RT)
600	35	65

Amperes (A)

2.00mm	2.40mm	2.50mm	3.15mm	3.20mm	3.25mm	4.00mm	5.00mm
45-55	50-80	50-80	80-110	80-110	80-120	100-140	150-180

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

Welding position



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