

CLASSIFICATION

AWS A 5.4	IS 5206	BS 2926	DIN 8556
E309L - 16	E23.12.LR26	E23.12.LR	E23.12.LR26

CHARACTERISTICS

A rutile coated stainless steel electrode depositing an extra low carbon 25/12 weld metal. The weld metal has excellent corrosion and oxidation resistance at high temperature. Welds are radiographic quality. Excellent arc stability and low spatter loss.

APPLICATIONS

The electrode are suitable for welding of AISI type 309, 309L steel, joining of straight chrome steels to low alloy steel or carbon steel deposition of buffer layer on mild steel. Building up mild steel to improve wear resistance and for building up worm parts of wear resisting steels, etc.

SPECIAL INSTRUCTION

Available in Vacuum Pack .Please Re dry the electrode at 250°C for one hour .If the packet is open for 12 hours or more ,5 times max. Do not use excessive currents. Use good fit-up joints. Adopt proper sequence. Remove the slag with a stainless steel wire brush.

WELDING POSITION



1G



2F



3G



4G

CHEMICAL COMPOSITION OF ALL WELD METAL

Element	C	Mn	Si	S	P	Cr	Ni
Percent (max)	0.04	0.50 - 2.00	1.00	0.020	0.03	22.0 -25.0	12.0 - 14.0

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL

UTS (N/mm2)	Elongation %
520 - 650	30 min

CURRENT CONDITION : AC/DC(+)

Size (mm)	Ø 2.50	Ø 3.20	Ø 4.00	Ø 5.00
Current (Amps)	55 - 90	85 - 110	130 - 150	150 - 190

PACKING DETAILS

DIA (mm)	Ø 2.50	Ø 3.20	Ø 4.00	Ø 5.00
LENGTH (mm)	350	350	350	350
WEIGHT /PKT (Kg)	2	2	2	2
PKT / BOX	5	5	5	5
WEIGHT /BOX (Kg)	10	10	10	10



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