

SC 309 MOL-17

Stainless steel electrode

Classification

AWS A 5.4: E 309 LMO- 17

DIN 8556: E 23 13 2 LR 23

DIN EN 1600: E 23 13 2 LR 12

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 316 L 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.

All weld metal mechanical properties (typical)

Tensile strength Rm (N/mm²)

600

Elongation (%)

35

ISO- V (J) RT

65

Typical weld metal chemical composition (%)

C

0.03

Si

0.90

Mn

1.00

Cr

23.50

Ni

13.10

Mo

2.50

S

0.012

P

0.015

Amperes (A)

2.5

50-80

3.15

80-110

4.00

100-140

5.00

150-180

Welding instruction

Redrying 1 h at 250° C if necessary. Interpass temperature: <200°C.



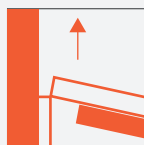
1G/PA



2F/PB



2G/PC



3G/PF



4G/PE

