

Stainless steel rutile type electrode

STARBLAZE PRIME 309LMo

Classification **AWS A5.4:** E 309LMo - 16 **DIN EN ISO 3581-A:** E 23 12 2 LR 12
DIN EN 1600: E 23 12 2 LR 12 **Werkstoff Nr:** 1.4459

Description and applications Low carbon Rutile-basic coated 23Cr 12Ni 2.50Mo stainless steel electrode with 15-25% ferrite 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. Highly cracking, corrosion and oxidation resistant. Also used as an universal repairing electrode in maintenance welding. Soft fusion, without spatters, nice aspect of the bead, very easy slag removal, easy re-striking. Packed in vacuum pack 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	13.00	2.50	0.012	0.015

All weld metal mechanical properties (typical)

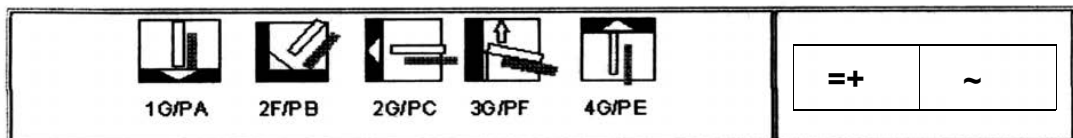
Tensile Strength R_m (N/mm ²)	Elongation A_5 (%)	Charpy Impact value (ISO-V J RT)
650	36	70

Amperes (A)

2.50mm	3.15mm	3.20mm	4.00mm	5.00mm
50-80	80-110	80-110	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 positions



Stellaris Specialities India Ltd.

(Division: StarBlaze India)

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