



A Stainless steel Electrode for dissimilar steel joining

CLASSIFICATION :	EN 1600	AWS A/SFA 5.4	IS 5206	APPROVALS:
	E 23 12 R 12	E 309-16	E 23.12 R26	IBR

KEY FEATURES :

- Rutile type medium coating
- 23/12 type SS deposit
- Exhibit excellent corrosion and oxidation resistance upto 1100°C
- Highest resistance to cracking
- Low dilution on mild and low alloy steels due to higher alloy content
- All position capability
- Radiographic quality weld

WELDING POSITION :



AC (70 OCV)/DCEP

TYPICAL APPLICATIONS :

- Dissimilar joints between stainless steels and low alloy or carbon steels
- Welding of AISI 309 type steels
- Buffer layer on low alloy and carbon steels
- Joining corrosion resistant clad steels

REDRYING CONDITION : 300°C for 1 hr. (Also available in vacuum packed condition)

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	Cr	Ni	S	P
Typical	0.05	1.6	0.5	23.6	12.9	0.02	0.02
Specification	0.10 max.	1.0-2.5	0.90 max	22.0-25.0	12.0-14.0	0.03 max	0.03 max

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	EL%	Ferrite No.
Typical	As Welded	610	38	13
Specification		560-660	30 min.	12-15

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Wt./Carton, Kg	Cartons/Box	Net wt./Box, Kg
2.5 x 300	50-75	2	5	10
3.15 x 300	80-100	2	5	10
4.0 x 300	110-140	2	5	10
5.0 x 300	150-180	2	5	10