

Standards

TS EN ISO 3581-A	: E 23 12 L R 32
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AWS A5.4	: E309L-17

Chemical Composition of Weld Metal % (Typical)

C	Si	Mn	Ni	Cr
0.03	0.8	0.8	12.6	23.0

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/+20°C)	Elongation (L ₀ =5d ₀) (%)
min. 440	540 - 720	min.47 J	min. 30

Typical Base Material Grades

- High-strength unalloyed and heat-treatable steels, ferritic Cr and austenitic CrNi steels, austenitic Mn steels
- Unalloyed tempered steels, tool steels, hard manganese steels, hard-to-weld steels

Features and Applications

- Rutile-coated low-carbon electrode for use in high-strength unalloyed and heat treatable steels, ferritic Cr and austenitic CrNi steels, austenitic Mn steels
- Similar-type austenitic stainless steels, dissimilar metals, buffer layers on mild and low-alloyed steels prior to build up or overlaying with any stainless electrodes, joining of corrosion resistant stainless steel with mild or low alloy steels, clad steels
- Good crack resistance wity hard-to-weld steels
- The weld metal is content to high ferrite %
- Requirement of re-drying for minimum 2 hours at the temperatures between 120°C and 200°C

Welding Positions



Current Type

D.C.(+) / A.C.

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010101083	2.50 x 250	3/32 x 10"	60-90	1550
3010101088	3.20 x 350	1/8 x 14"	80-120	3640
3010101093	4.00 x 350	5/32 x 14"	100-160	5320

Approvals: TSE, CE, SEPRO