

**Standards**

TS EN ISO 3581-A	: E 23 12 L R 32
EN ISO 3581-A	: E 23 12 L R 32
AWS A5.4	: E309L-16

**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 <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Impact Strength (ISO-V/+20°C)	Elongation (L <sub>0</sub> =5d <sub>0</sub> ) (%)
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, ferritic chromium steels, austenitic nickel chromium steels, hard-to- weld steels.

**Features and Applications**

- Similar-type austenitic stainless steels, dissimilar metals, buffer layers on mild and low-alloy 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 with hard to weld steels
- The weld metal is content to high ferrite %
- Requirement of re-drying for min. 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
3010101058	2.00 x 250	5/64 x 10"	50-85	950
3010101063	2.50 x 250	3/32 x 10"	60-90	1570
3010101073	3.20 x 350	1/8 x 14"	80-120	3610
3010101078	4.00 x 350	5/32 x 14"	100-160	5050

**Approvals:** TSE, CE, BV, ABS, SEPRO, RCB, DNV-GL