

Standards

TS EN ISO 3581-A	: E 23 12 2 L R 32
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AWS A5.4	: E 309LMo-17

**Chemical Composition of
Weld Metal % (Typical)**

C	Si	Mn	Mo	Ni	Cr
<0.03	0.7	0.8	2.8	13.0	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. 490	620-750	min.47 J	min. 30

Typical Base Material Grades

- Uses in high strength unalloyed and heat-treatable steels, ferritic / austenitic steels, austenitic Mn 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 steels electrode
- Joining of corrosion-resistant stainless steel with mild or low- alloy steels, clad steels
- The weld metal is content to high ferrite %
- Good cracking resistance with problematic steels
- 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
3010101113	2.50 x 250	3/32 x 10"	60-90	1570
3010101118	3.20 x 350	1/8 x 14"	80-120	3640
3010101123	4.00 x 350	5/32 x 14"	100-160	5050

Approvals: TSE, CE, SEPRO