

**Standards**

TS EN ISO 3581-A	: E 23 12 2 L R 32
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AWS A5.4	: E 309LMo-16

**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 <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> ) (%)
530	700	min.55 J	35

**Typical Base Material Grades**

- High strength unalloyed and alloyed steels, heat resistant steels, ferritic and austenitic steels

**Features and Applications**

- Welding of higher strength unalloyed and alloyed steels
- Welding of heat resistant steels
- Welding of high temperature pressure vessels, similar type of ferritic and austenitic steels
- Welding of corrosion and heat resistant steels, build-up or overlaying, buffer layers applications
- Weld metal contains higher amount of ferrite and has higher resistance to cracking
- 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
3010101098	2.50 x 250	3/32 x 10"	60-90	1570
3010101103	3.20 x 350	1/8 x 14"	80-120	3640
3010101108	4.00 x 350	5/32 x 14"	100-160	5050

**Approvals:** TSE, CE, SEPRO