HILCHROME 309R WELDING ELECTRODES Ø 2,5 X 300MM - E309L-17 - E 23 12 LR 32

Standards

- AWS A5.4: E309L-17
- EN ISO 3581-A: E 23 12 L R 3 2
- Working material number: 1.4332

Type of coating

- Rutile

Current type

- AC/DC

Welding positions

- All positions, except vertical downward

Basic materials to be welded

- High-strength steels, unalloyed and alloy heat-treatable steels; stainless steel, ferritic chromium steel and austenitic CrNi steel; austenitic manganese steel
- Chemically resistant weld coatings ranging from ferritic-perlitic steels to fine-grain steels, including heat-resistant fine-grain steel
- Bonding dissimilar materials

Applications

- Power generation
- Repair and maintenance
- Oil and gas industry
- Processing industry

Chemical composition

- Carbon (C): 0.02%
- Manganese (Mn): 0.8%
- Silicon (Si): 0.7%
- Chromium (Cr): 23.2%
- Nickel (Ni): 12.5%

Mechanical properties

- Condition: as welded
- 0.2% Yield strength: ≥ 400 MPa
- Tensile strength: ≥ 550 MPa
- Elongation Lo = 5d: ≥ 30%
- Impact values:
    - 20 ºC: ≥ 47 J
    - -60 ºC: ≥ 32 J

HI 23093525 - W20710		
Welding current max.	110	A
Elongation min.	30	%
Tensile strength min.	550	N/mm²
Yield strength min.	400	N/mm²
Material number	1.4332	
Welding process	MMA	
ImpactValue	20°C ≥ 47	J
Diameter	3,2	mm
Length	350	mm
Weight	4,4	kg
AWS standard	AWS A5.4: E309L-17	
EN standard	EN ISO 3581-A: E 23 12 LR 32	
Welding positions	All positions, except vertical downwards	
Coating type	Rutile	