Product Data Sheet

E 'Manual metal-arc welding'

OK 67.75

Prepared by	Qualified by	Approved by	Reg no	Cancelling	Reg date	Page
A-C Thorsson	Tero Borg	Tapio Huhtala	EN007277	EN007123	2016-06-15	1 (2)

REASON FOR ISSUE

Approvals revised. DNV removed, and DNV-GL added.

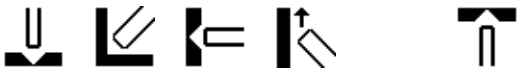
GENERAL

Basic coated stainless steel electrode for welding steels of the type 24Cr 13Ni, welding transition layers when surfacing mild steel with stainless, joining dissimilar steels and welding root runs in the stainless side of clad steels.

Polarity: DC+

Alloy Type: Austenitic CrNi
Coating Type: Basic
Ferrite Content: FN 8-15

WELDING POSITIONS



1 2 3 4 6

CLASSIFICATIONS Electrode

EN ISO 3581-A	E 23 12 L B 4 2
SFA/AWS A5.4	E309L-15
Werkstoffnummer	1.4332

APPROVALS

ABS	Stainless
DNV-GL	VL 309
LR	SS/CMn
NAKS/HAKC	2.5-5.0 mm
Seproz	UNA 272580
VdTÜV	00633

APPROVAL COMMENT

NAKS/HAKC: Valid for lot numbers starting with SB

CHEMICAL COMPOSITION

All Weld Metal (%)

	Min	Max	Nom
C		0.04	
Si	0.20	0.70	
Mn	1.80	2.50	
P		0.025	
S		0.020	
Cr	23.0	25.0	
Ni	12.0	14.0	
Mo		0.50	
Cu		0.3	
N		0.08	
Ferrite FN			11

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MECHANICAL PROPERTIES OF WELD METAL

	ISO	AWS	
	As welded	As welded	
Properties	**Min**	**Min**	**Typ**
Rp0.2 (MPa)	380	380	470
Rm (MPa)	520	520	600
A4 (%)		30	35
A5 (%)	30		
Z (%)		40	50
Charpy V at 20°C (J)	47	47	75
Charpy V at -50°C (J)		47	64
Charpy V at -80°C (J)	32	32	55

Comments:

Interpass temp. < 150 °C. Hardness all weld metal 190-230 HV.

ECONOMICS & CURRENT DATA

Dimension (mm)	Current (A)		W	η	N	B	H	T	U	Welding
Ø x Length	Min	Max								Positions
2.5 x 300	50	80	1.8	120	0.73	78	1.1	42	22	1,2,3,4,6
3.2 x 350	80	110	3.5	120	0.73	39	1.5	60	24	1,2,3,4,6
4.0 x 350	80	150	5.4	120	0.73	25	2.3	62	26	1,2,3,4,6
5.0 x 350	160	220	8.5	120	0.73	17	3.4	65	27	1,2

W = Weight (kg / 100 electrodes)

η = Efficiency (g weld metal x 100 / g core wire)

N = Effective value (kg weld metal / kg electrodes)

B = Changes (number of electrodes / kg weld metal)

H = Deposit rate at 90% of max current (kg weld metal / hour arc time)

T = Fusion time at 90% of max current (s / electrode)

U = Arc voltage (V)

OTHER DATA

Hardness data:
all weld metal in cladding application: 213 HV10

Redrying 200°C, 2h.