BOHLER FOX S 309L-16

SMAW rutile electrode for special applications

Classification	
AWS A5.4	**EN 1600**
E309L-16	E 23 12 L R 22

Characteristics and typical fields of application

Electrode designed for dissimilar welding between stainless steel and mild steel or low alloy steels.

Base Materials

Dissimilar joint welds between high strength, mild steels and low alloyed with stainless steels.

Typical analysis of solid wire (wt.-%)

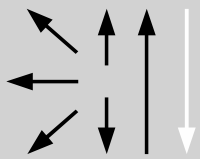
C	Si	Mn	Cr	Ni	Mo
0.02	0.7	0.8	23	12	0.02

Ferrite Number ≈ 12 FN (WRC'92)

Mechanical properties of all-weld metal

Heattreat-ment	Yield strength R_e N/mm^2	Tensile strength R_m N/mm^2	Elongation (L_0=5d_0)	Impact work ISO-V KV J	
	MPa	MPa	%	+ 20 °C	–60 °C
As Welded	445	555	37	52	39

Operating data



Polarity
DCEP/AC

Scaling Temperature : Approx. 950°C
Interpass temperature : 150°C
Heat Input: Max. 2.0 KJ/mm
Rebaking for 3 h at 250 – 280°C
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Approvals

ABS

Size, Packaging and Electrical Operating Data

Size mm	Kg / Pack	Kg / Box	Amperage (A)
2.50 × 300	3.63	10.89	50-80
3.25 × 350	4.10	12.30	70-120
4.00 × 350	4.10	12.30	100-150