



A low carbon stainless steel Electrode for buffer layer and dissimilar steel joining

CLASSIFICATION :	EN 1600	AWS A/SFA 5.4	IS 5206	APPROVALS:
	E 23 12 L R 12	E 309L-16	E 23.12 LR26	IRS/NPCIL

**KEY FEATURES :**

- Rutile type coating
- High ferrite content for highest resistance to cracking
- Low dilution on mild and low alloy steels due to higher alloy content
- Extra low carbon 23/12 type deposit
- Exhibit excellent corrosion and oxidation resistance upto 1100°C
- Suitable for all position
- Radiographic quality welds

WELDING POSITION : 



AC (70 OCV)/DCEP

**TYPICAL APPLICATIONS :**

- Dissimilar joints between stainless steels and low alloy or carbon steels
- Welding of AISI 309, 309L type steels
- For buffer layer on low alloy and carbon steels
- Joining corrosion resistant clad steels

REDRYING CONDITION : 300°C for 1 hr. (Also available in vacuum packed condition)

**CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :**

	C	Mn	Si	Cr	Ni	S	P
Typical	0.03	1.7	0.5	23.9	13.2	0.02	0.02
Specification	0.04 max	1.0-2.5	0.90 max	22.0-25.0	12.0-14.0	0.03 max	0.03 max

**MECHANICAL PROPERTIES OF ALL WELD METAL :**

	Condition	UTS, MPa	EL%	Ferrite No.
Typical	As Welded	560	36	12
Specification		520-600	30-40	10-15

**PARAMETERS - PACKING DATA :**

Ø x L, mm	Amperage, A	Wt./Carton, Kg	Cartons/Box	Net wt./Box, Kg
2.5 x 300	50-75	2	5	10
3.15 x 300	80-100	2	5	10
4.0 x 300	110-140	2	5	10
5.0 x 300	150-180	2	5	10

EQUIVALENT : GMAW wire:Miginox 309L GTAW filler:Tiginox 309L FCAW wire:Miginox FC 309L