



AWS/ASME SFA-٥,٤ **E ٣٠٩ MoL-١٦**
 Comparable No.of material **١,٤٤٥٩**
 DIN ٨٥٥٦ **E ٢٣ ١٣ ٢ L R ٢٦**
 prEN ١٦٠٠ **E ٢٣ ١٢ ٢ L R ١٢**

Application/properties:

This electrode is suitable for joining of dissimilar steels, (austenitic steels to ferritic steels) and for depositing claddings austenitic. Weld metal consists of with approximately ١٥% delta-ferrite. Claddings on alloyed or low-alloyed steel are already corrosion resistant in the first layer. Highest operating temperature for dissimilar steel joints is +٣٠٠°C; at higher temperature AMA ١٦٠G electrode shall be used. Fine droplet metal transfer, good wash-in of joint sides, finely-rippled bead surface, easily removable slag, easy arc striking and restriking are some properties of this electrode.

Weld metal analysis in % (typical values):

C	Mn	Si	Cr	Ni	Mo
١,٠٢٥	١,٩	٠,٧	٢٢,٥	١٣,٥	٢,٦

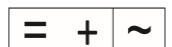
Mechanical Properties of all-weld metal: (single values are typical values)

Tensile Strength (N/mm ^٢)	Yield Strength ٠,٢% (N/mm ^٢)	Elongation A٥ (%)	Impact energy(j) ISO - V
			+٢٠°C
٦٤٠	٤٢٠	٣٠	٥٠

Welding Parameters		
Diameter (mm)	Length (mm)	Amperage (A)
٢,٥	٢٥٠	٦٠ - ٩٠
٣,٢٥	٣٠٠ - ٣٥٠	٩٠ - ١٢٠
٤,٠	٣٥٠	١٠٠ - ١٦٠
٥,٠	٣٥٠	١٤٠ - ٢١٠



OCV>٧٠V



Materials:

DIN EN Standard	١.٤٣٠.١ X٥CrNiMo ١٧ ١٢ ٢; ١.٤٣٠.٤ X٢CrNiMo ١٧ ١٣ ٢; ١.٤٣٢.٩ X٢CrNiMoN ١٧ ١٣ ٣; ١.٤٣٠.٦ X٢CrNiMoN ١٧ ١٢ ٢; ١.٤٣٠.٨ G-X٢CrNiMo ١٨ ١٠; ١.٤٣٣.٦ X٥CrNiMo ١٧ ١٣ ٣; ١.٤٥٨.١ G-X٥CrNiMoNb ١٨ ١٠; ١.٤٣٣.٥ X٢CrNiMo ١٨ ١٤ ٣; ١.٤٣٣.٦ X٥CrNiMo ١٧ ١٣ ٣; ١.٤٥٧.١ X٢CrNiMoTi ١٧ ١٢ ٢; ١.٤٥٧.٣ X١٠CrNiMoTi ١٨ ١٢; ١.٤٥٨.٠ X٢CrNiMoNb ١٧ ١٢ ٢ G-X١٠CrNiMoNb ١٨ ١٠
Other Standard	ASTM/ACI A٢٤٠/A٣١٢/A٣٥١: (TP)٣١٦L; CF-٣M; (TP)٣١٦L; (TP)٣١٦LN; (TP)٣١٦; ٣١٦Ti; ٣١٦Ti; ٣١٦Cb

Rebaking: required at ٣٥٠°C to ٤٠٠°C for ٢ hours.