

# STARINOX 309L

## ELECTROD SEMI-BAZIC / SEMI-BASIC ELECTRODE



### CLASIFICARE / STANDARDS

|                             |                |
|-----------------------------|----------------|
| SR EN 1600 (EN ISO 3581-A): | E 23 12 L R 12 |
| AWS A5.4:                   | E309L-16       |

### AUTORIZARI / APPROVALS

|      |      |
|------|------|
| LRS: | 309L |
| DNV: | 309L |

### CARACTERISTICI PRINCIPALE

Electrozi cu invelis semi-bazic ce depun un metal cu un continut de carbon de max. 0.04%, destinat sudarii otelurilor inoxidabil austenitice cu 22-25% Cr si 12-14% Ni de tipul AISI 309 si pentru oteluri refractare. Este destinat de asemenea sudarii imbinarilor eterogene. Indicad in particular pentru realizarea straturilor tampon in cazul incarcarii otelurilor carbon cu otel inoxidabil de tipul 308 si 316. Comportare la sudura excelenta, fara stropire, dupa solidificare zgura se indeparteaza foarte usor. Temperatura maxima de lucru +1000°C. Metalul depus are un continut de ferita controlat.

### MAIN FEATURES

Semi-basic electrode suitable for welding of austenitic steels having 22-25% Cr and 12-14% Ni (i.e. AISI 309). Maximum service temperature: +1000°C. High resistance to embrittlement. Suitable for joining of dissimilar steels. Excellent weldability with a spatter free arc; self releasing slag combined with a very smooth bead appearance.

### DOMENII DE APLICATIE

Recipienti sub presiune, inclusiv industria chimica si petrochimica; Strat tampon in cazul placarii.

### MAIN APPLICATIONS

Vessels, boilers fabrication (including chemical and petrochemical); First layer for stainless weld overlay.

### POZITII DE SUDARE / WELDING POSITIONS



1G 2F 2G 3G 4G 5G AWS  
PA PB PC PF PE PF EN

CURRENT / CURRENT: DC+, AC

### ANALIZA CHIMICA A METALULUI DEPUȘ % / ALL - WELD METAL CHEMICAL ANALYSIS %

| C      | Mn          | Si          | S       | P       | Ni          | Cr            | FN (WRC)   |
|--------|-------------|-------------|---------|---------|-------------|---------------|------------|
| ≤ 0.04 | 0.50 - 1.00 | 0.50 - 0.90 | ≤ 0.020 | ≤ 0.025 | 12.0 - 14.0 | 22.50 - 24.50 | 8.0 - 14.0 |

### CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

| Tratament termic/Heat treatment | Rm N/mm <sup>2</sup> | Rs N/mm <sup>2</sup> | E % 5d | Kv J +20°C |
|---------------------------------|----------------------|----------------------|--------|------------|
| Stare sudată/As welded          | ≥ 520                | ≥ 400                | ≥ 30   | ≥ 60       |

### DEPOZITARE - CALCINARE

Înainte de sudare electrozii se vor pastra in locuri uscate la temperatura camerei. Odata deschis pachetul, a se pastra la 90° - 150° C.

### STORAGE - REBAKING

Keep dry and store at room temperature. Once opened, store at 90° - 150° C.

### CURENTI DE SUDARE / AMPERAGE

| 2.5     | 3.20     | 4.0       |
|---------|----------|-----------|
| 60 - 80 | 80 - 100 | 110 - 140 |

### AMBALARE / PACKING: TUB / CAN

| Diametru                                    | mm | 2.5               | 3.20              | 4.00              |
|---|----|-------------------|-------------------|-------------------|
| Lungime / Length                            | mm | 300               | 350               | 350               |
| Greutate pe electrod / Weight per electrode | g  | 18.85             | 34.6              | 53.57             |
| Nr de fire pe pachet / Pcs. per innerbox    | n° | 197               | 130               | 85                |
| Greutate pachet / Weight per innerbox       | kg | 3.7               | 4.5               | 4.5               |
| Nr de fire pe cutie / Pcs. per outerbox     | n° | 591               | 390               | 255               |
| Greutate pe cutie / Weight per outerbox     | kg | 11.1              | 13.5              | 13.5              |
| Cod / Code                                  |    | 050303<br>250 300 | 050303<br>325 350 | 050303<br>400 350 |

Ambalarea in tuburi metalice ofera posibilitatea pastrarii electrozilor in medii cu umiditate atmosferica ridicata, eliminand necesitatea calcinarii dupa desigilarea tubului. Capacul din plastic nu permite rostogolirea tubului si permite protectia electrozilor dupa desigilarea tubului.

Packaging in tin cans offers the possibility of keeping the electrodes in highly humid environments, thus eliminating the necessity of rebaking once the can is opened. The plastic cap does not allow the can to roll over and protects the electrodes once the can is opened.

Datele mentionate pot fi modificate fara o notificare prealabila. / The above data may change without prior notice.