

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. Indicat 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



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 ²	Rs N/mm ²	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 250 300	050303 325 350	050303 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 opened. The plastic cap does not allow the can to roll over and protects the electrodes once the can opened.

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