



Selectarc 24/12Mo

Stainless Electrode
For Repairing

Classification

AWS A5.4 : E309MoL-17
ISO 3581-A: E 23 12 2 L R 3 2

EN 1600 : E 23 12 2 L R 3 2

Description & Applications

Low carbon Rutile-basic coated 23Cr 12Ni 2Mo stainless steel type electrode, used to weld on 316L stainless steels and for dissimilar joints between construction / mild steels and stainless steels. Intermediate layer for a 316L type cladding. Due to its high level of delta ferrite also used as an universal repairing electrode in maintenance welding. Highly crack resistant. Soft fusion, nice aspect of the bead, slag lifts by itself.

Base materials

Stainless steels:

UNS	Alloy	EN 10088	Material N°	UGINE
S31600	316	X5CrNiMo17-12-2	1.4401	UGINOX 17-10 M
S31603	316L	X2CrNiMo17-12-2	1.4404	UGINOX 18-11 ML
S31635	316Ti	X6CrNiMoTi17-12-2	1.4571	UGINOX 17-11 MT

+ for dissimilar joints, low alloy to stainless steels.

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Mo	Fe
<0.03	0.8	0.7	22.5	12.5	2.3	Rem.

All Weld Metal Mechanical Properties

R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)	
>450	>650	>25	+20°C	>55
			-40°C	>45

Welding Current & Instructions

Electrode	ØxL (mm)	2,0x300	2,5x300	3,2x350	4,0x350	5,0x450
Current	(A)	45	70	100	135	180

Redrying 1 hour at 250°C if necessary. Interpass temperature : < 150°C.

ind.12



= + ~ 70V

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