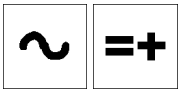
HILCO HILCHROME 309MoR

Stick electrodes – stainless steel – special purpose

AWS A5.4: E309LMo-17
EN ISO 3581-A: E 23 12 2 L R 3 2
Werkstoffnr. 1.4459

Coating type:
Rutile

Current:



Welding positions:

Hilchrome 309MoR is our rutile coated electrode for joining similar and dissimilar steels, buffering, joining hardenable and difficult-to-weld steels. Typical applications include joining high strength steels, un- and low alloyed structural steels and heat treatable steels. The electrode is suitable for joining clad steels. The Mo-alloyed electrode has an increased FN content (FN ~20) ensuring maximum cracking resistance. Hilchrome 309MoR is a core wire alloyed all-current type (AC/DC).

Base materials to be welded:

- Similar and dissimilar joining high strength, unalloyed and alloyed structural steels and heat treatable steels
- Un- and low alloyed boiler steels, CrNi(Mo) steels
- Combinations between ferritic and austenitic steels
- First layer in CrNiMo claddings AISI 316L and similar austenitic stainless steels
- Dissimilar joining

Applications:

- Power Generation
- Repair & Maintenance
- Oil & Gas Industry
- Process Industry

Chemical composition, wt. % weld metal – typical:

C	Mn	Si	Cr	Ni	Mo
0,02	0,8	0,7	23,0	12,5	2,7

Mechanical properties, weld metal – typical:

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %	Impact Values ISO-V J
As welded	≥ 490	≥ 630	≥ 25	20ºC ≥ 47 -20ºC ≥ 32

Packaging and welding data:

Dia. mm.	Length mm.	Weight (kgs) 1000 pcs.	Current A
2,5	300	18,5	60-80
3,2	350	36,8	80-120
4,0	350	52,2	100-160