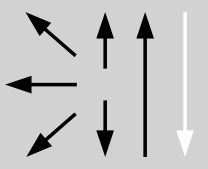


Classification					
AWS A5.4			EN ISO 3581-A		
E309LMo-17			E 23 12 2 L R		
Characteristics and typical fields of application					
Avesta 309LMo-17 is highly alloyed low carbon Stainless Steel electrode corresponding to spec. AWS 5.4, class E309MoL-17. The electrode is designed for dissimilar welding between Mo-Alloyed stainless with mild or low alloy steels. It can also be used for overlay welding, providing an 18 Cr 8 Ni 2 Mo deposit from the very first layer.					
Base Materials					
Over-alloyed electrode for surfacing unalloyed steel, joint welding molybdenum-alloyed stainless steel to unalloyed steel and for restoration welding of clad material.					
Typical analysis of all weld metal (wt.-%)					
C	Si	Mn	Cr	Ni	Mo
0.020	0.80	0.80	22.5	13.5	2.5
Ferrite Number ≈ 18 FN WRC92					
Mechanical properties of all-weld metal					
Heat treatment	Yield strength R _e N/mm ²	Tensile strength R _m N/mm ²	Elongation (L ₀ =5d ₀)	Impact work ISO-V KV J	
				+ 20 °C	- 60 °C
Min. AWS A5.4	-	520	30	-	-
As Welded	490	640	32	60	32
Hardness Approx. 220 Brinell					
Operating data					
		Polarity DCEP / AC Heat Input: Max. 2.0 kJ/mm Interpass temperature: Max. 150°C Scaling Temperature : Approx. 950°C Instruction for Re-drying: Re-dry for 3 h at 250-280°C before using			
Approvals					
ABS, DNV-GL, CWB, CE					
Size, Packaging and Electrical Operating Data					
Size mm	Kg / Pack	Kg / Box	Amperage (A)		
2.50 x 350	5.0	15.0	45 – 80		
3.25 x 350	5.0	15.0	70 – 120		
4.00 x 450	5.0	15.0	90 - 160		
5.00 x 450	5.0	15.0	150 – 220		