Standards:

EN ISO 3581-A:	E 23 12 LR 32
EN 1600:	E 23 12 LR 32
AWS A 5.4:	E 309 L-26
Mat.-No.:	~1.4332
Recovery:	**120%**

capilla® 309 L

Product description:

Rutile-basic coated stick electrode for overlay and fusion weldings of similar or lower alloyed heat-resistant CrNi-steels;

Service temperature ≤ 300°C ;

The weld metal is scaling resistant up to 1050°C;

Suitable for overlay weldings onto non-alloyed steels if an 18/8 Cr-Ni alloy composition has to be achieved in the first layer

Applications:

Claddings, buffer layers and joints, suitable for steels such as:

1.4541, 1.4550, 1.4710, 1.4712, 1.4727, 1.4729, 1.4740, 1.4742, 1.4780, 1.4825, 1.4826, 1.4828, 1.4878

Typical weld metal composition:

[wt. - %]

	C	Cr	Ni	Fe
Min.		**21**	**11**	
Max.	**0,03**	**23**	**13**	**Bal.**

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Tensile strength R_m:	550	[MPa]
Yield strength $R_{p0,2}$:	400	[MPa]
Yield strength $R_{p1,0}$:	430	[MPa]
Elongation (L=5d):	30	[%]
Impact strength (ISO-V):	55	[J]

Positions: all except PG

Redrying: 300°C/2h

Dimension:

Ø [mm]	Length [mm]	Welding current [A]
2,0	300	40 – 60
2,5	300	60 – 90
3,25	350	80 – 110
4,0	350	100 – 150
5,0	450	150 – 200

Polarity =(+)~

also available:
find in table of content

Capilla 309 L KB
Capilla 309 LR
Capilla 309 L MAG

Capilla 309 L WIG
Capilla G 309 L RM (tubular wire)