

Standards:

EN ISO 3581-A: E 23 12 LR 32
 EN 1600: E 23 12 LR 32
 AWS A 5.4: E 309 L-27
 Mat.-No.: ~1.4332

Recovery: 120%

capilla® 309 LR

Product description:

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

Service temperature of max. 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]	Polarity
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	

also available:
 find in table of content

Capilla 309 L KB
 Capilla 309 L
 Capilla 309 L MAG

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