BOHLER FOX S 309MoL-17

SMAW rutile electrode, high-alloyed, special application

Classification

AWS A5.4	EN 1600
E309LMo-17	E 23 12 L R 32

Characteristics and typical fields of application

Is highly alloyed low carbon electrode corresponding to AWS 5.4 309LMo-17. The electrode is designed for dissimilar welding between stainless and mild or low alloy steels but can also be used for overlay welding, providing an 18 Cr 8 Ni 2 Mo deposit from very first layer. It can also be used for welding high strength steels such as Hardox and Armox.

Base Materials

Over-alloyed electrode for surfacing unalloyed, joint welding molybdenum-alloyed stainless steel unallyed steel and welding clad material

Typical analysis of all weld metal (wt.-%)

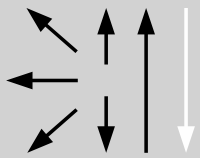
C	Si	Mn	Cr	Ni	Mo
0.026	0.90	0.75	22.9	12.9	2.3

Ferrite Number ≈ 20 FN (WRC'92)

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	
	MPa	MPa	%	+ 20 °C	–60 °C
As Welded	515	645	34	33	21

Operating data



Polarity
DCEP/AC

Scaling Temperature : Approx. 950°C
Interpass temperature : 150°C
Heat Input: Max. 2.0 KJ/mm
Rebaking for 3 h at 250 – 280°C
Electrode Identification : Bohler Fox S 309MoL-17

Approvals

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Size, Packaging and Electrical Operating Data

Size mm	Kg / Pack	Kg / Box	Amperage (A)
2.50 × 350	3.63	10.89	45-80
3.25 × 350	4.10	12.30	70-120
4.00 × 450	5.40	16.20	90-160
5.00 x 450	5.40	16.20	150-220