



Selectarc 24/12H

Heat resistant Electrode

Classification

AWS A5.4 : E309-16

ISO 3581-A : E 23 12 R 32

Description & Applications

High carbon Rutile-basic electrode with an austenitic stainless steel deposit containing about 14% ferrite for welding heat resistant steels of several grades including heat resisting ferritic steels.

The deposit is scaling resistant up to about 1000°C .

Typical industries and equipment: Heat treatment furnaces, ceramic industry, steam boiler, crude oil industry.

Soft fusion, nice aspect of the bead, self-releasing slag.

Base materials

Stainless steels for general use and for high temperature applications:

UNS	Alloy	EN	Material N°	UGINE
		GX40CrNi22-10	1.4826	
S30900	309	X15CrNiSi 20-12	1.4828	UGINOX R20-12
		GX25CrNiSi20-14	1.4832	
S30908	309S	X12CrNi23-13	1.4833	UGINOX R24-13S
		X10CrSi6	1.4712	
		X10CrAlSi7	1.4713	
		X10CrAl 18	1.4742	

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Mo	P	S	Cu	Fe
0.1	0.8	0.8	23	12.5	0.07	0.02	0.015	0.11	Rem.

All Weld Metal Mechanical Properties (typical)

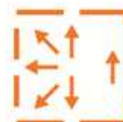
R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
450	600	30	+20°C 60

Welding Current & Instructions

Electrode	Ø x L (mm)	2,5x350	3,2x350	4,0x350
Current	(A)	70	100	135

Redrying at 250°C during 1 hour, if necessary. Inte rpass temperature : < 150°C.

ind.13



= + ~ 70V

Liability: This document is intended to assist the user in choosing the product. It is up to the user to verify

is suitable for applications for which it is intended.

The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for FSH Welding Group. **Fumes:** Consult information on MSDS, available upon request.