

***selectarc***

## Inox 309LB

**Stainless Steel Electrode**



**FSH WELDING GROUP**

INNOVATIVE WELDING CONSUMABLES

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### Classification

AWS A5.4 : E309L-15

EN 1600 : E 23 12 L B 42

ISO 3581-A : E 23 12 L B 42

### Description & Applications

Low carbon basic coated electrode 23 %Cr-12 %Ni type stainless steel with about 15% delta ferrite for welding dissimilar steels as stainless steels to low alloyed steels. Mainly used as first layer for cladding, when a final layer 308L or 347 is required.

Stable arc, good slag removal, regular weld beads.

#### Base materials

Stainless steels to construction steels:

UNS	Alloy	EN 10088	Material N°
S30900	309	X15CrNiSi20-12	1.4828
S30453	304LN	X2CrNiN18-10	1.4311
S30908	309S	X12CrNi23-13	1.4833

### Typical Weld Metal Composition ( % )

C	Si	Mn	Cr	Ni
0.03	0.4	1.6	22.5	12.5

### All Weld Metal Mechanical Properties (typical values as welded)

Rp0.2 ( MPa )	Rm ( MPa )	A5 ( % )	KV ( J )
500	640	38	+ 20 °C 80

### Welding Current & Instructions

Electrode	ØxL ( mm )	2,5x300	3,2x350	4,0x350	5,0x450
Current	( A )	70	95	130	170

Redrying: 1h at 250°C. Interpass temperature : < 200°C.



1G/PA



2F/PB



2G/PC



3G/PF



4G/PE

= +