BOHLER FOX N CN 23/12Mo-16

Low Carbon rutile coated SMAW electrode, high alloyed, stainless

Classification

AWS A5.4	EN ISO 3581-A	IS 5206		
E309LMo -16	E 23 12 2 L R	E 23 12 2 L R 26		

Characteristics and field of use

- Low Carbon, austenitic stainless steel stick electrodes with rutile coating
- The electrode is designed for dissimilar welding between stainless and mild or low-alloy steels.
- The electrode is well suited as a buffer layer when performing overlay welding on mild steels, providing an 18Cr 8 Ni deposit from the very first layer.
- High crack resistance with austenite –ferrite joints and weld cladding achieved by increased FN (~ 20)
- Designed to produce first class weld deposits with 100% radiography quality welds with very good positional welding characteristics with self-releasing slag.
- Excellent welding properties with DC power and high resistance to hot cracking in the weld metal.

Base Materials

High-alloyed low carbon electrode for sufacing unalloyed steel, joint welding molybdenum-alloyed stainless steel to unalloyed steel and for welding clad material. Suitable for the firsy layer of corrosior resiatant Mo –alloyed weld cladding on P235G1TH, P255G1TH, S255N –S500N and on creep resiatant , quenched and tempered fine grained structural steels.

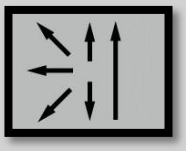
Typical Composition of all weld metal (wt. - %)

C	Si	Mn	S	P	Ni	Cr	Mo
q0.020	0.80	0.70	0.020	0.025	13.0	23.0	2.50

Mechanical Properties of all weld

Heat treatment condition	Yield strength R_e N/mm^2	Tensile strength R_m N/mm^2	Elongation (L_0=4d_0)	FN
	MPa	MPa	%	WRC-92
As Welded	NA	720	32	16 – 20

Operating data

Position	Polarity	Re-drying/baking conditions:	Ø(mm)	L	Amps
	AC/DCEP	Applicable only for electrodes exposed to the environment, prior to welding redrying at 250-350˚C for 2-3 Hrs recommended.	2.50	350	55-85
			3.15	350	70 -120
			4.00	350	120-160
			5.00	350	140-220

Size & Packaging	Size	Kg./Pack	Kg./Box
	2.50x350	2.0	10.0
	3.15x350	2.0	10.0
	4.00x350	2.0	10.0
	5.00x350	2.0	10.0

Approvals