BOHLER FOX N CN 23/12-16

Low Carbon rutile coated SMAW covered electrode, high alloyed, stainless

Classification

AWS A5.4

E309L-16

Features & Benefits

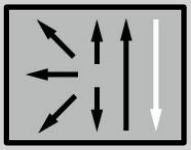
- Low Carbon, highly alloyed stainless steel stick electrodes with rutile coating
- The electrode is designed for dissimilar welding between stainless and mild or low-alloy steels.
- The electrode is well suited as a buffer layer when performing overlay welding on mild steels, providing an 18Cr 8 Ni deposit from the very first layer.
- It can also be used for some high temp. steels such as ASTM 309S.
- Provides increased delta ferrite contents in the weld deposit for safer & crack resistant dissimilar joint welds and surfacing.
- 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.
- Good gap bridging ability, easy weld pool and slag control as well as easy slag removal even in narrow preparations resulting in clean bead surfaces and minimum post weld cleaning.

Typical composition of All-weld Metal in wt-%

C	Si	Mn	Cr	Ni	FN (WRC1992)
0.022	0.8	0.65	23.0	12.9	10-14

Typical Mechanical Properties of All-weld Metal

Heat treatment condition	Yield strength	Tensile strength	Elongation ($L_0=4d_0$)
	MPa	MPa	%
As Welded	361	573	35

Position	Polarity
	
Available Sizes **Diameter x Length (mm)** 2.50 x 350 3.15 x 350 4.00 x 350 5.00 x 350	**Kg./Pack** 2 Kg/Pack X 5 = 1 Box