



HILCO HILCHROME 309R

Stick electrodes – stainless steel – special purpose

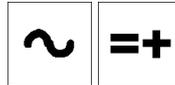
AWS A5.4: E309L-17

EN ISO 3581-A: E 23 12 L R 3 2

Werkstoffnr. 1.4332

Coating type:
Rutile

Current:



Welding positions:



Hilchrome 309R is our rutile coated electrode for welding corrosion resistant and heat resistant CrNi steels, joining dissimilar metals and buffering. Typical applications include joining high-strength steels, un- and low alloyed heat treatable steels, stainless, ferritic chromium and austenitic chrome-nickel steels, austenitic manganese steels. The electrode suitable for joining clad steels. The FN content (FN ~17) ensures good cracking resistance. Hilchrome 309R is a core wire alloyed all-current type (AC/DC).

Base materials to be welded:

- High strength, unalloyed and alloyed heat treatable steels; stainless, ferritic chromium and austenitic CrNi steels; austenitic manganese steels
- Chemically resistant weld claddings ranging from ferritic-pearlitic steels to fine grain steels, incl. high temperature fine grain steels
- Dissimilar joining

Applications:

- Power Generation
- Repair & Maintenance
- Oil & Gas Industry
- Process Industry

Chemical composition, wt. % weld metal – typical:

C	Mn	Si	Cr	Ni
0,02	0,8	0,7	23,2	12,5

Mechanical properties, weld metal – typical:

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %	Impact Values ISO-V J
As welded	≥ 400	≥ 550	≥ 30	20°C ≥ 47 -60°C ≥ 32

Packaging and welding data:

Dia. mm.	Length mm.	Weight (kgs) 1000 pcs.	Current A
2,5	300	18,0	60-80
3,2	350	33,8	80-110
4,0	350	51,1	110-140