

TECHNICAL DESCRIPTION

EUROTROD LC 54

CERTIFIED COMPANY:



CLASSIFICATION:

AWS A5.4: E 309 Mo L 16
EN 1600: E 23 12 2 LR 12

DESCRIPTION:

Rutile high-alloy extra-low carbon electrode (ELC) for chromium-nickel steels type 23 Cr/13 Ni/3 Mo and dissimilar joining of carbon steels to stainless steel. Also suitable as a buffer layer. Smooth running. Good striking and restriking. Regular appearance, finely rippled, smooth junction. Easy slag removal.

SUITABLE FOR:

AISI 309, 309 L	All chromium-nickel steels with low or medium C content, as well as titanium or Niobium stabilized stainless steels.

TYPICAL CHARACTERISTICS OF ALL-WELD METAL:

Chemical Analysis (%):

C	Si	Mn	Cr	Ni	Mo		
< 0,03	0,85	0,55	23,0	13,0	2,20		

Mechanical Properties:

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation 5d (%)	
>350	>550	>30	

PRODUCT INFORMATION:

WELDING PARAMETERS				VACUUM PACKING	
Diameter (mm)	Length (mm)	Recommended Current (A)	Current Type (Pole +)	Pieces /Packet (Un)	Weight /Packet (Kg)
2,0	300	30 – 50	AC/DC	155	1,8
2,5	300	50 – 75	AC/DC	100	1,8
3,2	350	75 – 110	AC/DC	55	2,0
4,0	350	110 – 150	AC/DC	35	2,0

APPROVALS:

- I.S.Q. (Welding Institute of Quality): Cert. N° 09/1301
- Bureau Veritas / Rinave: Cert. N° 09.L.2454

WELDING POSITIONS:

