

Super Optimal 309L-17

Features and Applications

- Rutile type low carbon MMA electrode for joining dissimilar steels (austenitic to ferritic steels) and for cladding of austenitic steels. Weld metal consists of austenite with approximately 15% delta ferrite. Cladding on unalloyed and low-alloy steels are corrosion resistant in the first layer.

Standards

AWS A 5.4 : E 309L- 17
 DIN 8556 : E 23 12 LR 23
 EN 1600 : E 23 12 LR 12

Mechanical Properties

ISO- V J RT	60
Tensile Strength N/mm ²	600
Elongation %	>35

Chemical Composition

C	Si	Mn	Cr	Ni	Mo	S	P
0.03	0.90	0.90	23.80	12.80	0.10	0.012	0.020

Welding Positions



Current Type

AC/DC (+)

Manufacturer's Approvals

Approvals on request

Product Information

2.0kg Vaccum Inner Pack with Plastic Tube / 10.0kg Master Pack

Part No.	Diameter	Length	Current
7442S	2.5mm	350mm	60-80
7443S	3.2mm	350mm	80-120
7444S	4.0mm	350mm	110-150

Super Optimal 309 MOL-17

Features and Applications

- Low carbon Rutile-basic coated 23Cr 12Ni 2Mo stainless steel type electrode, used to weld on AISI 309 & 316L stainless steels and for dissimilar joints between construction, mild steels and stainless steels. Intermediate layer for a 316 L type cladding.

Standards

AWS A 5.4 : E 309 LMO- 17
 DIN 8556 : E 23 13 2 LR 23
 EN 1600 : E 23 13 2 LR 12

Mechanical Properties

ISO- V J RT	65
Tensile Strength N/mm ²	600
Elongation %	35

Chemical Composition

C	Si	Mn	Cr	Ni	Mo	S	P
0.03	0.90	1.00	23.50	13.10	2.50	0.012	0.015

Welding Positions



Current Type

AC/DC (+)

Manufacturer's Approvals

Approvals on request

Product Information

2.0kg Vaccum Inner Pack with Plastic Tube / 10.0kg Master Pack

Part No.	Diameter	Length	Current
7446S	2.5mm	350mm	50-80
7447S	3.2mm	350mm	80-110
7448S	4.0mm	350mm	100-140