

Classification : Material code : 1.4459

ENISO 3581-A E 23 12 2 LR 12

AWSA 5.4 E309MoL-17

Homologations : TÜV, DB, CE

## Applications-types and characteristics :

Isarc 309 LMO is a rutile-coated electrode with an alternating current with an alloy core, designed to weld hard-to-weld steels and make anti-corrosion veneers.

An austenitic welding metal (CrNiMo 18/10/2) is obtained from the first layer.

The alloy is also suitable for welding buffer layers on plated metal sheets and for welding iron-based austenitic steels on ferritic subjected to serving temperatures of up to 300°C.

Due to its high level of alloy, Isarc 309 LMO provides crack-resistant welds. The addition of molybdenum provides greater corrosion resistance and traction resistance to high temperatures compared to molybdenum-free material 1.4839.

The welding metal is resistant to heat and calamity up to 1050°C.

Service temperature : from -20°C to +300°C

## Base metal :

Dissimilar seals from 1.4583 with H I / H II. 17 Mn 4. StE 355.

1.4583 with P235GH / P256GH, P295GH, P355N

Buffer layers (first layer) for plate drilling

Material support: HI/HII. 17Mn4.StE255 up to StE460.

P235GH/P256GH, P295GH, P255N up to P460N

1.4401 X5CrNiMo17-12-3

1.4404 X2CrNiMo17-13-2

## Mechanical properties of pure input metal: (types value)

Resistance to traction Rm N/mm <sup>2</sup>	Elasticity limit Rp0,2 N/mm <sup>2</sup>	Elongation A <sub>s</sub> %	Resistance to chocs ISO - V J à -20°C
650	450	30	48

## Analyse of welding material in % : (% of weight)

C	Si	Mn	Cr	Ni	Mo
<0.04	0.9	0.7	23	13	2.6

Electrical current : = + / ~ / 42 V

Welding passes : PA, PB, PC, PD, PE, PF

Post-drying : 1 h, 350° +/- 10°C (if necessary)

Diam/Long	Ampere (A)	Units/packaging	Units/box	kg/1000	kg/package	kg/box
2,0 x 300	30 - 60	339	1356	11,8	4,0	16,0
2,5 x 300	50 - 80	217	870	18,4	4,0	16,0
3,2 x 350	60 - 100	138	551	36,3	5,0	20,0
4,0 x 350	80 - 140	91	364	55,0	5,0	20,0
5,0 x 450	130 - 270	54	217	110,6	6,0	24,0

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