

Classification : E 299 R 23 S5 (DIN 8556)

E 299 R 32 (ISO 3581-A/EN 1600)

E 312-16 (AWS A5.4)

Properties :

Stainless repair and assembly electrode, austenitic-ferritic with rutile-basic coating. High mechanical characteristics, the metal deposited and particularly resistant to cracking. Soft fusion, beautiful cord appearance, self-detachable dairy.

Applications :

Welding of dissimilar steels (stainless steel with unaltered steel), materials deemed difficult to weld (tool and spring steel, manganese steel, moulded steel), repair of gears, jack rods, iron stainless steel parts. Also, suitable as underlay before hard reloading, and for reloading sharp or sharp tools.

Mechanical characteristics :

Re > 500 MPa	Rm = 700 - 850 MPa	A ₅ D > 20 %	Dureté : +/- 240 HB
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Packaging / Welding recommendations :

Ø mm	2,5	3,2	4	5
Poids étui (kg)	4	5	5	6,5
Intensité (A)	70	100	135	180

- Continuous current, + at electrode
- T° maximal between the passes: 250°C.
- Heating process 2h à 250 °C if necessary.

Welding positions :

