

4332 R

CATEGORY SMAW Stick Electrodes

TYPE Rutile coated electrode for welding stainless steels and dissimilar steels.

APPLICATIONS Joining heat resistant CrNi-steels of the same kind and also joining dissimilar metals such as steel to stainless steel. Cladding on low alloyed steels in case a 18/8 CrNi layer is required in the first layer. Scale resistant up to 1050°C.

PROPERTIES High corrosion resistance and excellent weldability on both AC and DC+. The weld deposit can undergo a high polish due to the low carbon content.

CLASSIFICATION

AWS	A 5.4: E 309L-17
EN ISO	3581-A: E 23 12 LR 32
DIN: W.Nr.	1.4332
DIN	8556: E 23 12 LR 26

SUITABLE FOR W.Nrs: 1.4541, 1.4550, 1.4710, 1.4712, 1.4727, 1.4729, 1.4740, 1.4742, 1.4780, 1.4825, 1.4826, 1.4828, 1.4878

APPROVALS CE approved

WELDING POSITIONS:



WELD DEPOSIT WEIGHT %

C	Mn	Si	Cr	Ni	Mo	Fe
<004	0.7	<0.9	23	13	-	Rem

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				20°C	-40°C	-60°C	
AW	>400	>550	>30	>47			

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A) DC+/AC	kg / can	kg / 6pack	kg / 1000
2.0	300	40-55	2.4	14.4	-
2.5	300	40-80	2.4	14.4	17.7
3.2	350	70-100	2.8	16.8	35.7
4.0	350	100-160	2.8	16.8	54.9
5.0	350	150-220	2.8	16.8	84.9

REDRYING TEMPERATURE 300°C/2hr