

EZ - KROM 40 R

CLASSIFICATION

EN ISO 3581-A	AWS / ASME SFA-5.4
E 23 12 2 LR 12	E309MoL-16

DESCRIPTION AND APPLICATION

Rutile coated electrode for welding of identical and similar stainless steels. Electrode is also used for welding dissimilar steels (for eg. stainless steel with mild steels), and for claddings on mild and low-alloy steels. Weld metal is of Cr-Ni-Mo austenitic type with delta-ferrite, resistant on temperatures up to 350°C.

MECHANICAL PROPERTIES OF THE ALL-WELD METAL

R _{p0.2} N/mm ²	R _m N/mm ²	A ₅ %	KV (-20°C) J
> 350	> 550	> 30	> 47

APPROXIMATE CHEMICAL COMPOSITION OF THE ALL-WELD METAL

	C	Mn	Si	Cr	Ni	Mo
%	≤ 0,03	0,9	0,8	22,5	12,5	2,7

RECOMMENDED WELDING CURRENT

Ø mm	2,5	3,2	4,0	5,0
A	60 - 80	80 - 110	110 - 150	150 - 190

PACKAGING

Electrode dimensions mm	Quantity per ton approx. pieces	Weight of packaging kg
Ø 2,5 x 300	52 800	1,1
Ø 3,2 x 350	26 300	1,1
Ø 4,0 x 350	18 200	1,2
Ø 5,0 x 450	9 100	5,5

APPROVALS

ABS (309 MoL-16); BV (UP); DNV (309 MoL); LR (SS/CMn); RS (A-9sp)



Marking: **EZ - KROM 40 R**
Dry before use 2h/300°C