

CRONITHERME-25/12

CODIFICATION :

	AWS	:	SFA 5.4 E309-16
	IS	:	5206 E23.12R16

CHARACTERISTICS AND APPLICATIONS :

A 25Cr - 12Ni electrode producing high strength stainless steel weld metal having good oxidation resistance up to 1100°C. The weld metal possesses excellent resistance to corrosion and oxidation. Ideal for welding 18/8 type steels to mild steels, clad side of 18/8 clad steels, lining of 12Cr steels on mild steels, overlays of ferritic steels, dissimilar steels and difficult to weld steels.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL :

Element	:	C	Mn	Si	Cr	Ni	S	P
Percent	:	0.06	1.80	0.50	23.5	12.5	0.020	0.020

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS	Elongation
(MPa)	(L = 4d)%
594	36

CURRENT AND PACKING DATA: AC / DC(+)

Size (mm)	:	5x350	4x350	3.15x350	2.5x350
Dia x Length					
Current Range	:	150-180	110-140	80-100	60-80
(Amps)					
Weight/Cartron	:	2.5	2.5	2.5	2.5
(kgs)					

APPROVALS: CIB-MP, BHEL, EIL, NPCIL, NTPC, PDIL

PRECAUTIONS:

1. Use lowest possible current, short arc and stringer bead.
2. Ensure the electrodes are dry. In case of moisture pick-up, redry the electrodes at 250-300°C for one hour.

NOTE : D&H 309-15 conforming to AWS E309-15 is also available.