

BÖHLER FOX CN 24/13

Covered electrode, high-alloyed, austenitic stainless, special applications

Classification	s										
EN ISO 3581-A						AWS A5.4 / SFA-5.4					
E 23 12 L B 2 2						E309L-15					
Characteristic	s an	d typical fields	of a	application							
layers. Final layer ce. Depending or	r(s) ai h the l	re normally perform base material being	ed v cla	with another stainless	s el ost	lectrode for finative	al prope	erties, mostly	for improv	requirements of buffe ed corrosion resistan- rvice temperatures up	
Base material	s										
For buffer layers	on w	eldable unalloyed, lo	ow-a	alloyed, high tensile a	and	l high tempera	ture ste	els.			
Typical analys	sis										
	С		Si	Si		Mn		Cr		Ni	
wt%	0.0	0.03		0.3		1.3		23.8		12.0	
Mechanical p	rope	rties of all-weld	me	etal - typical valu	es	(min. values	s)				
Condition	Yield strength R _{p0.2}			Tensile strength R _m		Elongation A (L_=5d)) Impact energy ISO-V KV J			
		MPa		MPa		%		20°C		-60°C	
u	440 (≥ 320)			565 (≥ 510) 39 (≥ 2		39 (≥ 25)	85			60	
u untreated, as-v	welde	d									
Operating data	а										
× † †	Ро	Polarity		DC+/AC		D		nsion mm	C	urrent A	
		Electrode		FOX CN 24/13 309 L		15 E 23	2.5 × 350		6	60 - 90	
identification		entification	12 L B				3.2 × 350		9	95 – 115	
						4.0 ×	350	1	20 – 145		
							5.0 x 450		1-	145 – 200	
		ue is recommended ass temperature det		iined by the base ma	teri	ial being cladd	ed.				
Approvals											

CE