


**24/12 Mo AC/DC+**
**STAINLESS STEEL**
**DESCRIPTION**

Low carbon Rutile-basic coated 23Cr-12Ni-2Mo stainless steel type electrode, used to weld on 316L stainless steels and for dissimilar joints between construction / mild steels and stainless steels. Intermediate layer for a 316L type cladding. Highly crack resistant. Soft fusion, nice aspect of the bead, slag lifts by itself.

**CLASSIFICATION**

AWS A5.4: E309MoL-17

EN 1600: E 23 12 2 LR 32

ISO 3581-A: E 23 12 2 LR 32

**BASE MATERIALS** 316, 316L, 316Ti + for dissimilar joints, low alloy steels to stainless steels.

**PROCEDURE**

Redrying 1 hour at 250°C if necessary. Interpass temperature : < 200°C.

**MECHANICAL PROPERTIES**

Tensile strength: > 94 274 psi (> 650 MPa)  
 Yield strength: > 65 266 psi (> 450 MPa)  
 Elongation: > 25 %  
 Impact (Charpy V): > 55 J at +20°C, > 45 J at -40°C

**TYPICAL WELD METAL COMPOSITION (%)**

C	Mn	Si	Cr	Ni	Mo
< 0.03	0.70	0.80	22.5	12.5	2.3

**WELDING PARAMETERS**

Diameter: 4.0 mm (5/32") 3.2 mm (1/8") 2.5 mm (3/32")  
 Amperage: 125-145 A 90-110 A 60-80 A

**WELDING POSITIONS**


1G/PA



2F/PB



2G/PC



3G/PF



4G/PE

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