

Порошковая проволока для дуговой сварки из нержавеющей стали ELOXCOR

Технические характеристики

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Stainless Steel Flux Cored Wire

ELOXCOR S 307

Standards

TS EN ISO 17633-A : T 18 8 Mn P M21/C1 1
EN ISO 17633-A : T 18 8 Mn P M21/C1 1
AWS A5.22 : E307T1-1/-4 (mod.)

Chemical Composition of Weld Metal (Typical)

C	Si	Mn	Cr	Ni
0.10	0.70	6.00	19.0	9.0

Mechanical Properties - (Typical): (With M21 gas)

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/+20°C)	Elongation ((L ₀ =5d ₀) (%))
480	630	50 J	40

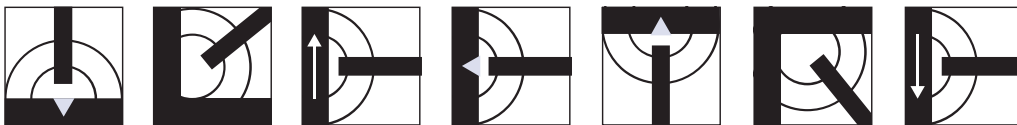
Typical Base Material Grades

- High-strength low alloyed and alloyed heat-treatable steels, armor steels, steels including 14 % Mn, ferritic chromium steels, heat-resistant steels, non-magnetic steels, dissimilar joints and repair welding.

Features and Applications

- ELOXCOR S 307 is rutile fast freezing type flux cored wire
- Work-hardening austenitic deposit in CrNiMn steel modified type 307
- Dissimilar joint, welding of steels of unknown types, armouring steels, buffering joining of 14 %Mn austenitic steels
- Service temperatures from -120°C to +300°C
- Shielding Gas: CO₂ or M21

Welding Positions



Current Type

D.C (+)

Operating Data

Product Code	Diameter (mm) / (inch)		Weight (Kg)	Package Type
6011100006	1.20	0.047"	15	D 300

Approvals: CE, SEPRO

Stainless Steel Flux Cored Wire

ELOXCOR S 308 L

Standards

TS EN ISO 17633-A	: T 19 9 L P M21/C1 1
EN ISO 17633-A	: T 19 9 L P M21/C1 1
AWS A5.22	: E 308 L T1-1/-4

Chemical Composition of Weld Metal (Typical)

C	Si	Mn	Cr	Ni
0.03	0.70	1.40	20.0	10.5

Mechanical Properties - (Typical): (With M21 gas)

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/-196°C)	Elongation ((L ₀ =5d ₀) (%))
460	620	34 J	36

Typical Base Material Grades

- (1.4306) X2CrNi19-11, (1.4301) X5CrNi18-10, (1.4311) X2 CrNiN 18-10, (1.4312) GX10CrNi18-8)
- AISI 304-304L-304LN, 302, 321-347, ASTM: A 157, Gr C9, A 320 Gr B8C or D

Features and Applications

- Rutile type, rapid hardening flux cored wire
- Weld metal structure is austenitic (CrNi alloyed, 308 type)
- Used in pharmaceutical, paper and food industry
- Ferritic stainless steel, high carbon 304 and stabilized 347 grades can be welded this wire
- Weld metal has resisting between -196°C and 400°C service temperature
- Shielding Gas: CO₂ or M21

Welding Positions



Current Type

FCAW / D.C (+)

Operating Data

Product Code	Diameter (mm) / (inch)		Weight (Kg)	Package Type
6011100255	1.20	0.047"	15	D 300

Approvals: ELOXCOR S 308 L (CO₂): DNV-GL, CE, SEPRO

Stainless Steel Flux Cored Wire

ELOXCOR S 309 L

Standards

TS EN ISO 17633-A	: T 23 12 L P M21/C1 1
EN ISO 17633-A	: T 23 12 L P M21/C1 1
AWS A5.22	: E309L T1-1/-4

Chemical Composition of Weld Metal (Typical)

C	Si	Mn	Cr	Ni
0.03	0.70	1.40	23.5	13.0

Mechanical Properties - (Typical): (With M21 gas)

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/-60°C)	Elongation ((L ₀ =5d ₀) (%))
460	580	40 J	35

Typical Base Material Grades

- High-strength unalloyed and heat-treatable steels, ferritic Cr and austenitic CrNi steels, austenitic Mn steels, unalloyed tempered steels, tool steels, hard manganese steels, ferritic chromium steels, austenitic nickel-chromium steels, hard-to-weld steels, similar-type austenitic steels, dissimilar metals, joining of corrosion resistant stainless steel with mild or low alloy steels, clad steels.

Features and Applications

- ELOXCOR S 309L is rutile fast freezing type flux cored wire
- Austenitic-ferritic deposit in over-alloyed CrNi steel type 309L, with optimised ferrite content for joining dissimilar metals
- Joining of steels with similar compositions and joining carbon steels to Stainless steels
- Buffering before cladding. Service temperatures from - 60°C to + 350°C
- Shielding Gas: CO₂ or M21

Welding Positions



Current Type

D.C (+)

Operating Data

Product Code	Diameter (mm) / (inch)		Weight (Kg)	Package Type
6011100256	1.20	0.047"	15	D 300

Approvals: ELOXCOR S 309 L (CO₂): DNV-GL, SEPRO, CE

Stainless Steel Flux Cored Wire ELOXCOR S 316 L

Standards

TS EN ISO17633-A	: T Z 19 12 3 L P M21/C1 1
EN ISO 17633-A	: T Z 19 12 3 L P M21/C1 1
AWSAS.22	: E316LT1-1/-4

Chemical Composition of Weld Metal (Typical)

C	Si	Mn	Cr	Ni	Mo
0.03	0.80	1.40	19.0	12.0	2.10

Mechanical Properties - (Typical): (With M21 gas)

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/-110°C)	Elongation ((L ₀ =5d ₀) (%))
490	600	35 J	32

Typical Base Material Grades

- (1.4401) X5CrNiMo 17-12-2, (1.4404) X2CrNiMo 17-12-2, (1.4435) X2CrNiMo 18-14-3, (1.4436) X3 CrNiMo 17- 13-3, (1.4571) X6 CrNiMoTi 17-12-2, (1.4580) X6 CrNiMoNb 17-12-2, (1.4583) X10 CrNiMoNb 18-12, (1.4409) GX2 CrNiMo 19-11-2
- AISI 316 L, 316 Ti, 316 Cb

Features and Applications

- Rutile type, rapid hardening flux cored wire
- Weld metal microstructure is austenite (CrNiMo alloyed, 316 type)
- Used in welding of high carbon and stabilized 316 grade steels, low carbon 316 L grade stainless steels, food, pharmaceutical, chemical dye and machinery and equipment industries
- Weld metal has resisting between -110°C and 400°C service temperature
- Shielding Gas: CO₂ or M21

Welding Positions



Current Type

FCAW / D.C (+)

Operating Data

Product Code	Diameter (mm) / (inch)		Weight (Kg)	Package Type
6011100257	1.20	0.047"	15	D 300

Approvals: ELOXCOR S 316 L (CO₂): DNV-GL, SEPRO, CE

Stainless Steel Flux Cored Wire

ELOXCOR S 2209

Standards

TS EN ISO 17633-A	: T 22 9 3 N L P M21/C 1 1
EN ISO 17633-A	: T 22 9 3 N L P M21/C 1 1
AWS A5.22	: E 2209 T1-1/-4

Chemical Composition of Weld Metal (Typical)

C	Si	Mn	Cr	Ni	Mo	N
0.03	0.80	1.40	23.0	9.0	3.20	0.14

Mechanical Properties - (Typical): (With M21 gas)

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/-60°C)	Elongation (L ₀ =5d ₀) (%)
630	780	32 J	28

Typical Base Material Grades

- (1.4462) X2CrNiMoN 22-5-3, (1.4362) X2 CrNiN 23-4, UNS S31803, S32205, J92295, S31500, S32304, S32404

Features and Applications

- Rutile type and rapid hardening flux cored wire
- Weld metal microstructure is austenite - ferritic
- The weld metal has an excellent resistance to stress corrosion, cracking and pitting
- Used in duplex stainless steel and similar materials
- Shielding Gas: CO₂ or M21

Welding Positions



Current Type

FCAW / D.C (+)

Operating Data

Product Code	Diameter (mm) / (inch)		Weight (Kg)	Package Type
6011100254	1.20	0.047"	15	D 300

Approvals: ELOXCOR S 2209: CDNV-GL, NK, RINA, SEPRO, CE

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