

## 4829 MoTi

**CATEGORY** SMAW Stick Electrodes

**TYPE** Rutile basic electrode for welding stainless steels and dissimilar steels.

**APPLICATIONS** Joining heat resistant CrNi-steels of the same kind and also joining dissimilar alloys such as steel to stainless steel. Cladding on low alloyed steels in case a 18/8/2 CrNiMo layer is required in the first layer.

**PROPERTIES** High corrosion resistance and excellent weldability on both AC and DC+.

**CLASSIFICATION**

AWS	A 5.4: E 309MoL
EN ISO	3581-A: E 22 12 R 3 2
DIN: W.Nr.	1.4829
DIN	8556: E 23 12 LR 23

**SUITABLE FOR** dissimilar welding of steel to stainless steels, heat resisting steels, W.Nrs: 1.4401, 1.4404, 1.4406, 1.4410, 1.4437, 1.4571, 1.4580

**APPROVALS** CE approved

**WELDING POSITIONS:**



**WELD DEPOSIT WEIGHT %**

C	Mn	Si	Cr	Ni	Mo
<003	0.8	0.7	22-24	11-13	2.5-3.5

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0.2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness HRC / HV
				20°C	-20°C	-60°C	
AW	>480	>630	>25	>47	>32		

AW: as welded

**WELDING PARAMETERS / PACKING**

D (mm)	Welding Parameters		Packing		
	Length (mm)	Current (A)	kg / can	kg / 6pack	kg / 1000
2.5	300	60-90	2.5	15	18.6
3.2	350	80-110	2.8	16.8	36
4.0	350	100-150	3.0	18	54
5.0	450	155-220	3.0	18	111.11

**REDRYING TEMPERATURE** 300°C/2hr (not often required).