

|   |                             |          |
|---|-----------------------------|----------|
|  | <b>TECNHICAL DATA SHEET</b> | FT-DQ59  |
|   | <b>EUROTROD LC 54</b>       | PÁG. 1/1 |

**CLASSIFICATION:**

AWS A5.4: E 309 Mo L 16  
ISO 3581-A- E 23 12 2 LR 12

**CERTIFIED COMPANY:**



**DESCRIPTION:**

Rutile high-alloy extra-low carbon electrode (ELC) for chromium-nickel steels type 23 Cr/13 Ni/3 Mo and dissimilar joining of carbon steels to stainless steel. Also suitable as a buffer layer. Smooth running. Good striking and restriking. Regular appearance, finely rippled, smooth junction. Easy slag removal.

**SUITABLE FOR:**

|                 |  |
|-----------------|--|
| AISI 309, 309 L | All chromium-nickel steels with low or medium C content, as well as titanium or Niobium stabilized stainless steels. |
|                 |  |
|                 |  |

**TYPICAL CHARACTERISTICS OF ALL-WELD METAL:**

**Chemical Analysis (%):**

| C      | Si   | Mn   | Cr   | Ni   | Mo   |  |  |
|--------|------|------|------|------|------|--|--|
| < 0,03 | 0,85 | 0,55 | 23,0 | 13,0 | 2,20 |  |  |

**Mechanical Properties:**

| Yield Strength<br>(N/mm <sup>2</sup> ) | Tensile Strength<br>(N/mm <sup>2</sup> ) | Elongation<br>5d (%) |  |  |
|--|--|----------------------|--|--|
| > 350                                  | > 550                                    | > 30                 |  |  |

**PRODUCT INFORMATION:**

| WELDING PARAMETERS |                |                            |                          | VACUUM PACKING         |                        |
|--------------------|----------------|----------------------------|--------------------------|------------------------|------------------------|
| Diameter<br>(mm)   | Length<br>(mm) | Recommended Current<br>(A) | Current Type<br>(Pole +) | Pieces /Packet<br>(Un) | Weight /Packet<br>(Kg) |
| 2,0                | 300            | 30 – 50                    | AC/DC                    | 155                    | 1,8                    |
| 2,5                | 300            | 50 – 75                    | AC/DC                    | 100                    | 1,8                    |
| 3,2                | 350            | 75 – 110                   | AC/DC                    | 55                     | 2,0                    |
| 4,0                | 350            | 110 – 150                  | AC/DC                    | 35                     | 2,0                    |

**APPROVALS:**

- Bureau Veritas / Rinave
- RINA

**WELDING POSITIONS:**

