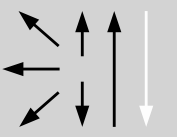


Classifications						
EN ISO 3581-A				AWS A5.4		
E 23 12 2 L R				E309MoL-17		
Characteristics and typical fields of application						
Avesta P5 is a high-alloy low carbon electrode designed for welding dissimilar joints between stainless and mild or low-alloy steels. It can also be used for overlay welding on mild steel, providing an 18 Cr 8 Ni 2 Mo deposit from the very first layer.						
Corrosion resistance:						
Superior to 316L. When used for overlay welding on mild steel a corrosion resistance equivalent to that of 1.4401/ASTM 316 is obtained already in the first layer.						
Base materials						
High-alloy low carbon electrode for surfacing unalloyed steel, joint welding molybdenum alloyed stainless steel to unalloyed steel and for welding clad material.						
Typical analysis of all-weld metal (wt.-%)						
	C	Si	Mn	Cr	Ni	Mo
wt-%	0.02	0.8	0.8	22.5	13.5	2.5
Mechanical properties of all-weld metal						
Heat-treat-ment	Yield strength R _e N/mm ²	Tensile strength R _m N/mm ²	Elongation (L ₀ =5d ₀)	Impact work ISO-V KV J		Hardness
	MPa	MPa	%	+20 °C	-40°C	HB
u	490	640	30	40	27	220
u untreated, as-welded						
Operating data						
	Polarity: DC (+)	Electrode identification:	ø (mm)	L mm	Amps A	
			2.0		30 – 60	
			2.5		45 – 80	
			3.25		70 – 120	
			4.0		90 – 160	
			5.0		150 – 220	
Approvals						
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