

EN 10204

	2.2	3.1
CHEMICAL	<input checked="" type="checkbox"/>	<input type="checkbox"/>
MECHANICAL	<input checked="" type="checkbox"/>	<input type="checkbox"/>

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Purchaser	SPECIALISED WELDING PRODUCTS LTD UNITED KINGDOM		
Order Nr			
Product Group	Covered electrode - stainless, high alloyed		
Brand Name	GEKA ELOX R 309 MoI ( SUPER6 309 MOL ) / 4.5 KG, PLASTIC BOX		
Standard	AWS A5.4:06 TS 2716 EN 1600:02		
Classification	E 309 MoL - 17 E 23 12 2 L R 32		
Size	4,00 mm		
Quantity	45,0 Kg		
Serial Nr	11-4081		
Charge Nr	081		

Chemical Composition of Weld Metal (%)																	
Charge Nr	C	Si	Mn	P	S	Cr	Ni	Mo	Cu	V	Al	Fe	-	-	-	-	-
AWS	<0,04	<1,0	0,5-2,5	<0,04	<0,03	22,0-25,0	12,0-14,0	2,0-3,0	<0,75	-	-	Rest/Kalen	-	-	-	-	-
TS/EN/ISO	<0,04	<1,2	<2,5	<0,03	<0,025	22,0-25,0	11,0-14,0	2,0-3,0	-	-	-	Rest/Kalen	-	-	-	-	-
081	0,033	0,694	0,770	0,018	0,001	22,256	12,129	2,753	0,045	0,084	0,001	Rest/Kalen	-	-	-	-	-

Mechanical Properties										
Tensile Test					Impact Test					
- EN 10002-1					- EN 10045-1					
Specimen preparation					Specimen preparation					
- EN 876					- EN 875 VWT 0/b					
Test	Temperature	R <sub>p</sub>	R <sub>m</sub>	A	Test	KV	KV	Hardness	Radiographic test	Comment
	°C	N / mm <sup>2</sup>	N / mm <sup>2</sup>	%L <sub>50</sub> =5d <sub>0</sub>	Temperature	Impact Strength	Average			
	°C	N / mm <sup>2</sup>	N / mm <sup>2</sup>	%L <sub>50</sub> =5d <sub>0</sub>	°C	J	J	-	-	
AWS	20	-	>520	>30	-	-	-	-	-	
TS/EN/ISO	20	>350	>550	>25	-	-	-	-	-	
	20	min. 490	620 - 750	min. 30	20	-	min. 47	-	-	



Quality Department

F186/00