Strip Electrode for Electroslag Overlay Welding

BA-STRIP 309LNb

Classification: EN ISO 14343-A: **B 23 12 Nb**
SFA-5.9: **EQ(309LNb)**

Main Application:
BA-STRIP 309LNb is a strip electrode for electroslag overlay welding (ESW) recommended to achieve composition similar to 309LNb corrosion resistant overlay weld deposit on mild steel and low alloy steels. When used as single layer the composition will be similar to AISI 347. BA-STRIP 309LNb is mainly used for corrosion resistant weld surfacing for several industries, very common in petrochemical applications.

Typical analysis and chemical composition acc. to EN ISO 14343-A and AWS A5.9: (Weight Percent)

Strip electrode	C	Si	Mn	Mo	Ni	Cr	Nb	P	S	Cu total
Typical analysis BA-STRIP 309LNb	0.018	0.3	1.9	0.1	12.5	24.0	0.8	0.020	0.013	
B 23 12 Nb acc. to ISO 14343-A	0.08	1.0	1.0 – 2.5	0.5	11.0 – 14.0	22.0 – 25.0	10x%C – 1.0	0.03	0.02	0.5
EQ(309LNb) acc. to AWS A5.9	0.03	0.30 – 0.65	1.0 – 2.5	0.75	12.0 – 14.0	23.0 – 25.0	10x%C – 1.0	0.03	0.03	0.75

Base Materials:
Mild steels and low alloy steels.

Suitable flux: BF 44

Flux type suitability is strongly dependent on its application. In combination with the strip electrode the most suitable flux should match the requirements of the plate material as closely as possible under the existing welding conditions. Further information can be obtained from the technical flux data sheets.

Package Forms:
Coils or wound spools as standard package forms for strip electrodes.

Dimensions:
30 x 0.5 mm, 60 x 0.5 mm; sizes and tolerances acc. to ISO 544 and AWS A5.9.
Other dimensions on request.

Strip Electrode Surface:
Smooth finish free from surface defects and foreign matter.