

AWS	E 309MoL-16
DIN	E 23 13 2 LR 23
EN	E 23 12 2 LR 12

MSSM 23/14V

For welding of low carbon 22%Cr – 12%Ni–Mo stainless steel

Applications

Build up welding of Cr–Mo steel or carbon steel. Welding of AISI (SUS) 316 or AISI (SUS) 316L to carbon steel. Clad steel side welding to AISI (SUS) 316 or AISI (SUS) 316L.

Characteristics:

MSSM 23/14 is rutile covering type electrodes for all–position welding, which have good usability and good weldability. Weld metals provide excellent corrosion resistibility and heat resistibility in the as–welded condition.

As MSSM 23/14 is of low carbon content, it can be used for welding of extra–low carbon stainless steel which contains Mo and for under laying of mother plates which contain considerably high carbon content.

Notes on usage

1. Keep the arc as short as possible and choose the welding current as low as possible.
2. Weaving width should be within two and a half times of electrode's diameter.
3. When the electrodes have absorbed moisture, dry them at 250–300 °C for 60–90 minutes before use.

Typical chemical composition of weld metal (%)

C	Mn	Si	Cr	Ni	Mo
0.025	0.70	0.90	22.50	13.50	2.60

Typical mechanical properties of weld metal

0.2% proof stress (N/mm ²)	TS N/mm ²	EL %
420	640	30

Size & recommended current range: (~ =+)

Product name	Order name	Diameter (mm)	Length (mm)	Amp.
MSSM 23/14V	332547	2.5	300	60–90
	332548	3.25	350	90–120
	332549	4.0	350	110–140

Welding Positions

