

EN 1600:1997: E 23 12 L B 2 2  
 AWS A5.4-92: E309L-15

**BÖHLER**  
**FOX CN 24/13**

SMAW stick electrode for special applications

## Description

Special basic coated electrode with controlled alloying elements to meet the metallurgical requirements of buffer layers. Stringer bead technique is recommended. Normally used in combination with different corrosion resistant claddings, depending on the base material also with an additional PWHT. For service temperatures up to +400 °C.

## Typical Composition of All-weld Metal

C	Si	Mn	Cr	Ni
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## Mechanical Properties of All-weld Metal

(*) yield strength $R_e$ N/mm <sup>2</sup> :		u	<b>430</b>	(≥ 320)
tensile strength $R_m$ N/mm <sup>2</sup> :			<b>570</b>	(≥ 520)
elongation A ( $L_0=5d_0$ ) %:			<b>35</b>	(≥ 30)
impact work ISO-V KV J	+20 °C:		<b>70</b>	(≥ 47)

(\*) u untreated, as-welded

## Operating Data



re-drying: if necessary:

**300-350 °C, min. 2 h**

electrode identification:

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**ø mm**

3.2

4.0

**L mm**

350

350

**amps A**

95-115

120-145



Preheating and interpass temperature acc. the base materials.

## Base Materials

For buffer layers on weldable unalloyed, high tensile, high temperature or alloyed base metals.

## Approvals and Certificates

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