

Avesta 2304

Stick electrode

Classifications

high-alloyed

EN ISO 3581-A:

E 23 7 N L R

Characteristics and field of use

Avesta 2304 is primarily designed for welding the duplex stainless steel Outokumpu 2304® and similar grades. Thanks to the low molybdenum content, corrosion resistance in nitric acid containing environments is very good. The weldability of duplex steels is excellent but the welding should be adapted to the base material, considering fluidity, joint design, heat input etc.

Base materials

For welding steels such as					
Outokumpu	EN	ASTM	BS	NF	SS
2304	1.4362	S32304	-	-	2327

Typical analysis of all-weld metal (Wt-%)

C	Si	Mn	Cr	Ni	Mo	N
0.02	0.8	0.8	24.8	9.0	0.2	0.12

Ferrite 40 FN WRC-92

Mechanical properties of all-weld metal

Heat Treatment	Yield strength 0.2%	Tensile strength	Elongation ($L_0=5d_0$)	Impact values in J CVN	
	MPa	MPa	%	+20°C:	-40°C:
untreated	640	780	23	40	30

Operating data

Polarity = + / ~

Dimensions (mm)	Amperage A
2.5	50-80
3.25	80-120
4.0	100-160