

**Avesta P5**

Stick electrode

**Classifications**

high-alloyed

EN ISO 3581-A:

AWS A5.4:

E 23 12 2 L R

E309MoL-17

**Characteristics and field of use**

Avesta P5 is a high-alloyed low carbon electrode designed for welding dissimilar joints between stainless and mild or low-alloy steels. It can also be used for overlay welding, providing an 18 Cr 8 Ni 2 Mo deposit from the very first layer. It can also be used for welding highstrength steels.

**Base materials**

For welding steels such as					
Outokumpu	EN	ASTM	BS	NF	SS
High-alloyed low carbon electrode for surfacing unalloyed steel, joint welding molybdenum alloyed stainless steel to unalloyed steel and for welding clad material.					

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


C	Si	Mn	Cr	Ni	Mo
0.02	0.8	0.8	22.5	13.5	2.5

Ferrite 20 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	490	640	30	30	27

**Operating data**

	Polarity = + / ~
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Dimensions (mm)	Amperage A
2.0	30-60
2.5	45-80
3.25	70-120
4.0	90-160
5.0	150-220