

PRODUCT DATA SHEET

MIG/TIG 309LMo



MIG/TIG 309LMo is mainly used under high dilution conditions, particularly, dissimilar welds between stainless and CMn steels. There are no comparable base materials.

Materials to be Welded

There are three main areas of application: buffer layers and clad steels, dissimilar joints and hardenable steels.

Classifications

AWS	A5.9	ER309LMo (nearest)
EN	I4343-A	E23 12 2 L
EN	I4343-B	SS 309LMo

Typical Chemical Analysis

% Carbon	0,015	% Chromium	22,0
% Manganese	1,7	% Nickel	14,5
% Silicon	0,5	% Molybdenum	2,7
% Sulphur	0,005	% Copper	0,2
% Phosphorous	0,015	% Ferrite	10,0

Typical Mechanical Properties (All weld metal) TIG

0,2% Proof Stress	350 MPa min
Tensile Strength	550 MPa min
% Elongation on 5d	25 min
Charpy V-Notch at +20°C	>90 J min

Packing Data MIG (DC+)

Diameter (mm)	Current		Item Number	Pack Mass (kg)
	Amps (A)	Volts (V)		
1,2	220	26	W033048	15,0

TIG (DC-)

Diameter (mm)	Current		Item Number	Pack Mass (kg)
	Amps (A)	Volts (V)		
1,6	100	12	W030429	5,0
2,0	100	12	W030430	5,0
2,4	100	12	W030431	5,0

Suggested gas for welding: Stainshield® (MIG), Argon (TIG)

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