

SUBARC 309LMo



Mainly used under high dilution conditions, particularly dissimilar welds between stainless and CMn steels. There are no comparable base materials. There are 3 main areas of application: Buffer layers and clad steels, Dissimilar joints and Hardenable steels.

MATERIALS TO BE WELDED

There are 3 main areas of application :
Buffer layers and clad steels, Dissimilar joints and Hardenable steels.

CLASSIFICATIONS

AWS	A5.9	ER309LMo
BS	EN 12072	23 12 2 L
DIN	8556	SG X8 XrNiMo 23 13 (1.4459)

CHEMICAL ANALYSIS

% Carbon	0.015	% Chromium	22.00
% Manganese	1.700	% Nickel	14.50
% Silicon	0.500	% Molybdenum	2.700
% Sulphur	0.005	% Copper	0.200
% Phosphorous	0.015	% Ferrite	10.00

**TYPICAL MECHANICAL PROPERTIES
ALL WELD METAL**

Tensile Strength	610 MPa
0.2% Proof Stress	440 MPa
Elongation on 4d	35%
Impact Energy 20°C	95J
*Flux Dependant	

PACKING DATA

(DC+)

Diameter (mm)	Current (A)		Item Number	Pack Mass (Kg)
	Amps	Volts		
2.40	350	29	078-156	25

Suggested flux : Afrox Flux MH or DX-9

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