

# S-309Mo.16

Type : Rutile

## Conformances

AWS A5.4/ ASME SFA5.4 E309Mo-16

JIS Z3221 ES309Mo-16

EN ISO 3581-A-E 23 12 2 R

ABS AWS A5.4 E309Mo-16

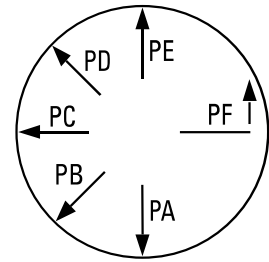
## Applications

- Welding of dissimilar steels (root pass)

## Features

- Good resistance to heat and crack
- Easy to remove slag
- Good bead appearance

## Welding Position



## Current

AC or DC ±

## Redrying Conditions

350°C (662°F) X 1hr

## Diameter / Packaging

Diameter	Length	P.V.C	
		packet	carton
mm (in)	mm (in)	2.5kg(5.5lbs)	10kg(22lbs)
2.6 (3/32)	350 (14)	✓	
3.2 (1/8)	350 (14)	✓	
4.0 (5/32)	400 (16)	✓	
5.0 (3/16)	400 (16)	✓	
6.0 (15/64)	450 (18)	✓	

## Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Ni	Mo
0.03	0.77	1.21	0.026	0.015	23.3	12.6	2.4

## Typical Mechanical Properties of All-Weld Metal

TS MPa(lbs/in <sup>2</sup> )	EL (%)
662 (96,100)	35.7

## Typical Welding Parameters / Amp.(A)

Diameter mm (in)	2.0 (5/64)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)
Length mm (in)	300 (12)	300 (12)	350 (14)	350 (14)	350 (14)
F & HF	25~55	50~85	70~115	95~145	135~180
V-up, OH	20~50	45~80	65~110	85~135	-

SWAW

SAW

GMW

GTAW

FCW

Non-FERROUS

APPENDIX