

# S-309MoL.16

Type : Rutile



## Conformances

AWS A5.4/ ASME SFA5.4 E309LMo-16  
 JIS Z3221 ES309LMo-16  
 EN ISO 3581-A-E 23 12 2 L R  
 DNV-GL NV 309MoL (-20°C)  
 TÜV EN ISO 3581-A - E 23 12 2 L R  
 DB EN ISO 3581-A-E 23 12 2 L R  
 CE

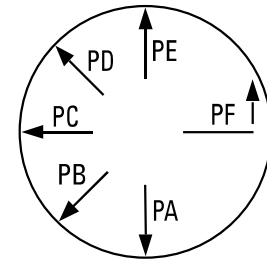
## Applications

- Welding of dissimilar steels
- Welding of low carbon 22%Cr-12%Ni-2.5%Mo stainless steel

## 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 mm (in)	Length mm (in)	P.V.C	
		packet 2.5kg(5.5lbs)	carton 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
0.02	0.72	1.30	0.027	0.013	23.3	12.7	2.4

## Typical Mechanical Properties of All-Weld Metal

TS MPa(lbs/in <sup>2</sup> )	EL (%)
690 (99,000)	33.8

## 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	-