



## EI 309MoL

Coated Electrode for Stainless Steels -

### Standards

AWS/ASME SFA - 5.4	E309LMo-16
EN ISO 3581 - A	E 23 12 2 L R 12
TS EN ISO 3581 - A	E 23 12 2 L R 12

### Approvals & Certificates

TSE

### Properties and Applications

Rutile type stainless electrode for joining dissimilar steels (austenitic steels to ferritic steels) and for austenitic claddings. Weld metal consists of austenite with approx. 15% delta-ferrite. Claddings on unalloyed and low-alloy steels are already corrosion resistant in the first layer, due to Mo (molybdenum) content. Higher operating temperature for joints between dissimilar steels is +300°C. In the cases of higher temperatures, use ENI 422 electrodes. Fine metal droplet transfer, good fusion of joint faces, finely ripped bead surface, easy slag removal, easy arc striking and restriking.

### Typical Chemical Values of Weld Metal

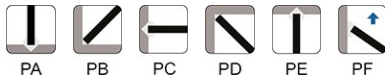
Type of Analysis	C	Si	Mn	Cr	Ni	Mo
Weld Deposit	0.02	0.9	0.95	23.3	12.2	2.5

### Typical Mechanical Values of Weld Metal

Test Condition	Tensile Strength (N/mm <sup>2</sup> )	Elongation A5 (%)	Charpy V-Notch Properties (J)
As welded	700	30	20°C → 50

### Application Information

#### Welding Positions



#### Polarity:



#### Welding Parameters & Efficiency

Diameter x Length (mm)	Current (A)
2.00x300	40-60
2.50x300	50-80
3.25x300	80-120
3.25x350	80-120
4.00x350	100-165

### Packaging Information

Product Code	Diameter x Length (mm)	Quantity per Box	Box Gross Weight (Kg)	Boxes per Outer Box	Outer Box Gross Weight (Kg)	Packaging Type
13010DDEM2	2.00x300	205 AD	2.62	3	8.00	Plastic Box
13010DJEM1	2.00x300	145 AD	1.82	9	16.60	VAC Box
13010DJEM2	2.00x300	143 AD	1.79	9	16.30	VAC Box
13010GDDEM2	2.50x300	128 AD	2.62	3	8.00	Plastic Box
13010GJEM1	2.50x300	90 AD	1.82	9	16.60	VAC Box
13010GJEM2	2.50x300	89 AD	1.79	9	16.30	VAC Box
13010MDEM2	3.25x300	77 AD	2.62	3	8.00	Plastic Box
13010MJEM1	3.25x300	55 AD	1.85	9	16.80	VAC Box
13010MJEM2	3.25x300	54 AD	1.79	9	16.30	VAC Box

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13010NDEM2	3.25x350	66 AD	2.64	3	8.10	Plastic Box
13010NJEM1	3.25x350	55 AD	2.15	9	19.60	VAC Box
13010NJEM2	3.25x350	53 AD	2.04	9	18.60	VAC Box
13010QJEM1	4.00x350	35 AD	2.05	9	18.70	VAC Box
13010QJEM2	4.00x350	35 AD	2.04	9	18.60	VAC Box

#### Storage & Re-Drying Information

It can be dried maximum 5 times.  
It should be stored in a dry room (relative humidity < 50%, room temperature > 20°C) on wooden pallets.  
It has to be dried at 350°C for 2 hours.



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## CONTACT

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