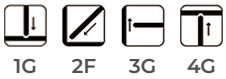
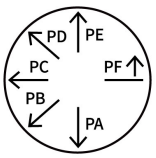
S-309Mo.16

Classification

AWS A5.4/ASME SFA-5.4 E309Mo-16
JIS Z 3221 ES309Mo-16
EN ISO 3581- A E 23 12 2 R
KS D7014 E309Mo-16

Welding Positions





Features

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

Polarity

AC or DC+

Application Areas

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

Redrying Conditions

350°C (662°F) X 1hr

Approvals

ABS
✓

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

C	Si	Mn	P	S	Cu	Ni	Cr	Mo
0.03	0.60	1.0	0.026	0.015	0.04	12.6	22.7	2.4

Typical Mechanical Properties of All-Weld Metal

Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft·lbs)
716(104)	32	-20(0) -60(-75)	42(31) 37(27)

Diameter / Welding Parameters / Packaging

Diameter mm(in)	Length mm(in)	F & HF	V-up, OH	Packaging
2.0 (5/64)	300 (12)	25~55	20~50	PVC - Packet 2.5kg(5.5lbs), Carton 10kg (22lbs)
2.6 (3/32)	300 (12)	50~85	45~80	
3.2 (1/8)	350 (14)	70~115	65~110	
4.0 (5/32)	350 (14)	95~145	85~135	
5.0 (3/16)	350 (14)	135~180	-	