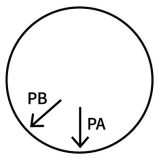
Supercored 309MoL

Classification

AWS AWS A5.22/ ASME SFA-5.22 E309LMoT0-1/-4
JIS Z 3323 TS309LMo-FB0
EN ISO 17633-A-T 23 12 2 L R M21/C1 3

Welding Positions





Features

- Flat and horizontal fillet position welding
- High deposition rate and efficiency

Polarity

DC +

Application Areas

- 22%Cr-12%Ni-2.5%Mo stainless steels
- Dissimilar welds between carbon, low alloy steels to stainless steels
- Buffer layer welding for cladding, overlays

Shielding Gas

100% CO2
Ar+20~25% CO2

Approvals

BV	DNV	LR
✓	✓	✓

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

Shielding Gas	C	Si	Mn	P	S	Cu	Ni	Cr	Mo
100% CO2	0.03	0.6	1.4	0.02	0.007	0.11	12.6	22.6	2.5
Ar + 20% CO2	0.03	0.6	1.5	0.021	0.008	0.12	12.7	22.9	2.5

Typical Mechanical Properties of All-Weld Metal

Shielding Gas	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft·lbs)
100% CO2	710 (103)	28	-20 (0)	34 (25)
Ar+20~25% CO2	711 (103)	31	-20 (0)	34 (25)

Diameter / Welding Parameters / Packaging

Wire Diameter mm(in)	Current (A)	Packaging
1.2 (0.045)	140~210	Spool 5kg(11lbs), 12.5(27.6lbs), 15kg(33lbs)
1.6 (1/16)	180~290	