

ST-309MoL

Dissimilar metals such as stainless steels and carbon steels

Conformances

AWS A5.9/ ASME SFA5.9 ER309LMo
JIS Z3321 YS309LMo
EN ISO 14343-A W 23 12 2L
BV SA309Mo

Applications

- Clad steel side welding of 316, 316L STS clad steel

Features

- Excellent corrosion resistance
- Excellent resistance to heat
- Excellent Arc stability and bead wetting

Current

DC -

Shielding Gas

Ar

Diameter / Packaging

Diameter	
mm (in)	5kg*1000
1.0 (0.039)	
1.2 (0.045)	
1.6 (1/16)	✓
2.0 (5/64)	✓
2.4 (3/32)	✓
2.6 (0.10)	✓
3.2 (1/8)	✓

Typical Chemical Composition of the Wire(%)

C	Si	Mn	Cr	Ni	Mo
0.02	0.35	1.8	23.2	13.7	2.5

Typical Mechanical Properties of All-Weld Metal

TS MPa(lbs/in ²)	EL (%)
650 (94,200)	32

SMW

SAW

GMW

GTAW

FCW

Non-FERROUS

APPENDIX