Technical data sheet 011121MBA	Cored welding wire # TUBE S 309LMo-S	Welding Alloys

CLASSIFICATION

ASME IIC SFA 5.22 / AWS A 5.22: EC309LMo
ASME IIC SFA 5.9 / AWS A5.9: EC309LMo
EN ISO 17633-A: T 23 12 2 L M NO 3

DESCRIPTION

- Cored stainless steel wire for submerged arc welding
- 24% chromium - 12% nickel – 3% molybdenum, low carbon deposit
- Attractive bead appearance without residual slag, outstanding slag release even in narrow gaps
- Mineral additions to the core improve mechanical strength and welding characteristics

APPLICATIONS

- Welding stainless steels of similar composition or ferritic stainless steels.
- Joining stainless steels to mild and low-alloyed steels.
- Rebuilding and buffering before cladding or weld overlay.

Examples

Dissimilar welds between stainless steel types 304, 304L, 316, 316L, 318, 316Ti, 321, 410 or ferritic stainless steel types 1.4713, 1.4724, 1.4742, 3Cr12, to non or low alloyed CMn steels.
Buffer layer before cladding with austenitic, duplex or superduplex material.
For service temperatures up to 400°C.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	Mo
0.020	1.40	0.70	24.5	12.5	2.80

Typical ferrite level: 30 FN

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A_5 [%]	CVN [J]
550	350	25	+20°C: 32

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2%[MPa]	A_5 [%]	CVN [J]
720	540	27	+ 20°C: 50

FLUX DESCRIPTION

	WA FLUX 325	WA FLUX 385	WA FLUX 415	WA ULTRAFLUX
EN ISO 14174 class	S A AB 1 65	S A AF 2 64	S A FB 1 55	S A FB 1 55

PACKAGING

Diameter	2.0 mm - 3.2 mm
Standard packaging	EN ISO 544 - ASME IIC SFA-5.2 M
	Coil: B450
Weight	25 kg

Other packaging and other diameters: please consult us

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.