

GETIG 309LMo

IDENTIFICATION: ER 309LMo

APPROVAL: CE

SPECIFICATIONS: AWS/SFA 5.9: ER309LMo

CHARACTERISTICS:

Solid wire deposits a 24 % Cr / 13 % Ni/ 2.5% Mo austenitic stainless steel weld metal with a ferrite content about FN 16. The high alloy level and high ferrite content enables the weld metal to tolerate dilution from carbon and low alloy steels without hot cracking.

COMPOSITION OF THE WIRE (RANGE) %

C	Mn	Si	Cr	Cu
0.03 max	1.0-2.50	0.30-0.65	23.0-25.0	0.50 max
Ni	S	P	Mo	
12-14	0.03 max	0.03 max	2.0-3.0	

APPLICATIONS:

- Buffer layer on mild steel or low alloy steels.
- Joining of clad steels and dissimilar joints between stainless and mild or low alloy steels.
- Joining of ferrite-martensitic stainless steels.
- Welding of similar composition, 309Mo type stainless steel.
- Joining type 304/304L, 347, 321, 316/316L and duplex stainless steel to mild and low alloy steels.

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	YS (MPa)	ELN % (L=4D)	CVN impact value	
			Temp	Joules
580-680	410-510	35-45	0°C	50-100

SHIELDING GAS: Argon 99.99% 6-12 l/min.

WELDING CURRENT: DC(-)

RECOMMENDED CURRENT AND PACKING DATA:

CORROSION RESISTANCE:

Good resistance to general and intergranular corrosion. Also good resistance to oxidising acids and cold reducing acids.

SIZE (mm)	LENGTH (mm)	PACKING/BOX
1.6	1000	5 x 4 = 20 Kg
2.0	1000	5 x 4 = 20 Kg
2.5	1000	5 x 4 = 20 Kg
3.15	1000	5 x 4 = 20 Kg

Manufactured by: GEE LIMITED

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