

❖ Product Description

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| I. Extra low carbon 23Cr/12Ni type steel solid wire | III. The addition of Mo gives high strength and pitting corrosion resistance |
| II. Maximum cracking resistance due to high ferrite content | IV. Radiographic weld quality |

❖ Range of Application

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| I. For welding AISI 309Mo steels | III. For buffer layer on low alloy carbon steels before deposition of 316 type weld metal |
| II. For dissimilar joints between 316 type and low alloy or carbon steels | |

❖ Classification

- AWS/SFA 5.9 ER309-LMo

❖ % Chemical Composition

Type of Wire		C	Mn	S	Si	Cr	Cu	Mo	P	Ni
ER309-LMo	Min	-	1.0	-	0.30	23.0	-	2.0	-	12.0
	Max	0.03	2.5	0.03	0.65	25.0	0.75	3.0	0.03	14.0

❖ Mechanical Properties of all weld metal

Condition	UTS, MPa (Min)	YS, MPa (Min)	% Elongation	Charphy "v" Notch Impact @ -30°C
As Welded	550	-	30	-

❖ Wire Size & Welding Position

- Diameter in mm- 0.60, 0.80, 0.90, 1.00, 1.20, 1.40, 1.60
- Weld Position- All position

❖ Current & Gas Flow

- DCEP; 15-22lit/min

❖ Packaging

Sizes Available in mm	0.60, 0.80, 0.90, 1.00, 1.20, 1.40, 1.60								
Packing Code	A	B	C	D	E	F	G	H	I
Packing Available	SD 100	SD200	SD270	SD 270	SD300	SD300	100kg Drum Pack	250kg Drum Pack	350kg Drum Pack
Net Weight of Wire	1KG	2KG	12.5KG	15KG	12.5KG	15KG	100KG	250KG	350KG

Special Notes: -

- (1) All the value above mentioned are typical values.
- (2) Usually all chemistry and mechanical properties will depend on actual wire chemistry and arc voltage used for welding.

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