

❖ Product Description

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| I. The wire with 23Cr% and 12%Ni. | III. Excellent corrosion and oxidation resistance up to 1100°C |
| II. The addition of Mo gives high strength and pitting corrosion resistance | IV. Radiographic weld quality |

❖ Range of Application

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| I. Suitable for welding AISI 309Mo type steels | III. Good for applying a buffer layer on low alloy and 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	Si	S	P	Cr	Ni	Mo	Cu
ER309-LMo	Min	-	1.0	0.30	-	-	23.0	12.0	2.0	-
	Max	0.03	2.5	0.65	0.03	0.03	25.0	14.0	3.0	0.75

❖ Wire Size and Weld Position

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| • Diameter in mm-1.6, 2.0, 2.40, 3.20, 4.00 and 5.00. | • All position |
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❖ Current and Gas- Flow Rate

- DCEN & 8-15 lit/min

❖ Packaging

Sizes available in cut length of 1000mm	1.60,2.00,2.40,3.20,4.00,5.00			
Packing Code	A		B	
Packing Available	5kg PLASTIC TUBE	20KG BOX	10KG PAPER TUBE	20KG BOX
Net Weight of Wire	5	20	10	20

Special Note: -

All the value above mentioned are typical values.

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

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