

Stainless Steel SMAW Electrodes

G309LMo

AWS A5.4 E309LMo-16
JIS Z 3221 ES309LMo-16
ISO 3581-A-E23 12 2 L R

Product Features:

- Lime titanium oxide type covered electrode for low carbon content stainless steel.
- All deposited weld metal contains approximately 2.5%Mo to get better strength, acid and heat resistance than 309L.
- Adequate Ferrite content to provide low crack sensitivity.

Applications:

- Welding of SUS 309MoL stainless steels.
- Cladding or welding of SUS316, 316L stainless steel to carbon steel or low alloy steel.

Typical chemical composition of all weld metal (wt%)

C	Si	Mn	Ni	Cr	Mo	Fe
0.04	0.59	0.88	13.17	23.24	2.76	Bal.

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %
554	642	43

Size (mm) & recommended welding parameters (A) AC or DC+

Diameter / Length	2.6/300	3.2/350	4.0/350	5.0/350
Flat position	50~85	85~120	115~150	150~190
Vertical / overhead position	50~80	75~105	95~130	----

Note:

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