

Stainless Steel Flux Cored Wire

GMX309LMo

AWS A5.22 E309LMoT1-1/4
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JIS Z 3323 TS309LMo-FB1
ISO 17633-A-T 23 12 2 L R C1 1, M21 1

Product Features:

- Rutile type gas shield flux cored arc welding wire, austenite structure weld metal.
- Weld metal contains Mo element to get good high temperature strength, good crack and inter-granular corrosion resistance.
- Low spatter loss and easy slag removal.

Applications:

- Dissimilar metal welding of SUS316L to carbon steels or low alloy steels.
- Cladding of SUS316, 316L to carbon steels and low alloy steels.

Typical chemical composition of all-weld metal (wt%)

C	Si	Mn	Ni	Cr	Mo	Fe
0.03	0.62	1.53	12.64	22.41	2.61	Bal.

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %
539	646	32

Size (mm) & recommended welding parameters

Diameter		1.2mm	1.6mm
Polarity		DC+	DC+
Ampere (A)	Flat / Horizontal position	160~250	200~300
	Vertical / overhead position	90~130	----
Shielding Gas		CO ₂ / 80%Ar+20%CO ₂	CO ₂ / 80%Ar+20%CO ₂

Note:

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