

DESCRIPTION

Executive 309LMo provides superior weldability, low spatter and smooth beads with easy slag removal. Designed for welding of low carbon 22% Cr-12% NiMo or for welding dissimilar metals such as molybdenum-containing austenitic stainless steels to carbon steels.

For joining stainless steel to carbon and low-alloy steels for service below 600°F (316°C), and for overlaying of carbon and low-alloy steels. The presence of molybdenum provides pitting resistance in a halide environment and helps provide high temperature ductility in dissimilar joints. The ferrite level for this electrode deposit is approximately 20 FN.

APPLICATIONS & FEATURES

Suitable for welding critical chemical vessels and AISI 316L stainless steel. The weld metal remains its strength at high temperature. It has flat bead shape and good wettability. This alloy is used in paper mills and power plants to provide greater corrosion resistance.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Cr	Ni	Mo	Mn	Si	P	S	Cu	Nb	
0.022	22.57	12.30	2.68	1.31	0.72	0.014	0.003	0.16	0.01	
Tensile Strength:		105,800 PSI min						Elongation:		33%
Yield Strength:		71,300 PSI min								

TYPICAL WELDING PARAMETERS

Diameter	Voltage	Amperage	WFS (in/min)	Shielding Gas*
.045"	24	130	225	100% CO ₂ or Ar + 20-25% CO ₂
.045"	27	175	320	
.045"	30	240	530	
.062"	27	195	152	100% CO ₂ or Ar + 20-25% CO ₂
.062"	31	260	260	
.062"	34	320	360	

*Shielding gas flow rate 35 to 50 CFH. For 100% CO₂ use two volts higher than shown

STANDARD PACKAGING

FCAW 33-lb plastic spools 1,980-lb pallet

CLASSIFICATION

AWS/SFA 5.22, Class **E309LMoT0-1/4**

