



309LMo-17 AC/DC+

STAINLESS STEEL

DESCRIPTION

Low carbon Rutile-basic coated 23Cr-12Ni-2Mo stainless steel type electrode, used to weld on 316L stainless steels and for dissimilar joints between construction / mild steels and stainless steels. Intermediate layer for a 316L type cladding. Highly crack resistant. Soft fusion, nice aspect of the bead, slag lifts by itself.

CLASSIFICATION

AWS A5.4: E309MoL-17 EN 1600: E 23 12 2 LR 32 ISO 3581-A: E 23 12 2 LR 32

BASE MATERIALS: 316, 316L, 316Ti + for dissimilar joints, low alloy steels to stainless steels.

PROCEDURE

Redrying 1 hour at 250°C if necessary. Interpass temperature : < 200°C.

MECHANICAL PROPERTIES

Tensile strength: > 94 354 psi (> 650 MPa)
 Yield strength: > 65 322 psi (> 450 MPa)
 Elongation: > 25 %
 Impact (Charpy V): > 55 J at +20°C, > 45 J at -40°C

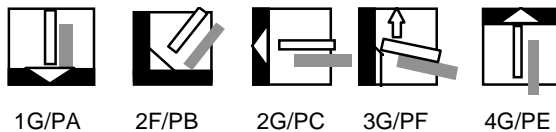
TYPICAL WELD METAL COMPOSITION (%)

C	Mn	Si	Cr	Ni	Mo
< 0.03	0.70	0.80	22.5	12.5	2.3

WELDING PARAMETERS

Diameter: 5.0 mm (3/16")	4.0 mm (5/32")	3.2 mm (1/8")	2.5 mm (3/32")	2.0 mm (5/64")
Amperage: 180 A	135 A	100 A	70 A	45 A

WELDING POSITIONS



Rév. :7_01

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