OK Autrod 309MoL

A continuous solid corrosion resistant wire of 309LMo type. OK Autrod 309MoL is used for overlay welding of unalloyed and low alloyed steels and for welding of dissimilar steels such as 316L to unalloyed and low alloyed steels when Mo is essential.

Specifications	
Classifications	EN ISO 14343-A : G 23 12 2 L SFA/AWS A5.9 : ER 23 12 2 L SFA/AWS A5.9 : ER309LMo (mod)
Approvals	CE : EN 13479 UKCA : EN 13479 VdTÜV : 07352

Approvals are based on factory location. Please contact ESAB for more information.

Alloy Type	Austenitic (with approx. 8 % ferrite) "309LMo" 22 % Cr - 15 % Ni - 3 % Mo - Low C
Shielding Gas	M12, M13 (EN ISO 14175)

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
As Welded	400 MPa	600 MPa	31 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
As Welded	20 °C	95 J
As Welded	-60 °C	65 J

Typical Weld Metal Analysis %									
C	**Mn**	**Si**	**S**	**P**	**Ni**	**Cr**	**Mo**	**Cu**	**N**
0.02	1.3	0.3	0.002	0.02	14.5	21	2.6	0.1	0.07

Typical Weld Metal Analysis %	
Nb	**FN WRC-92**
0.01	8

Typical Wire Composition %									
C	**Mn**	**Si**	**S**	**P**	**Ni**	**Cr**	**Mo**	**V**	**Cu**
0.010	1.5	0.35	0.003	0.018	15.0	21.5	2.6	0.1	0.12

Typical Wire Composition %			
N	**Nb**	**Co**	**FN WRC-92**
0.06	0.01	0.06	9

Deposition Data				
Diameter	**Current**	**Voltage**	**Wire Feed Speed**	**Deposition Rate**
0.8 mm	50-140 A	16-22 V	3.4-11.0 m/min	0.8-2.7 kg/h
1.0 mm	80-190 A	16-24 V	2.9-8.4 m/min	1.1-3.1 kg/h
1.2 mm	180-280 A	20-28 V	4.9-8.5 m/min	2.6-4.5 kg/h
1.6 mm	230-350 A	24-28 V	3.2-5.5 m/min	3.0-5.2 kg/h