KFW-309LMo

Shielding Gas: CO_2 or Ar+20%CO_2

Classification

AWS	A5.22	E309LMoT1-1/4
JIS	Z3321	TS309LMo-FB1
EN	17633-A	T 23 122 LP C1/M21 2
GB	T 17853	E309LMoT1-1/4

Applications and Features

(1) Weld metal contains Mo and low carbon contents, which provide superior corrosion resistance.

(2) It is suitable for joining stainless steel to carbon steel or low alloy steel.

(3) It has flat bead shape and good wettability.

Welding Position

All Positions

Welding Instruction

(1) For welding dissimilar metals, please refer to Appendix I.

(2) For other instructions, please refer to Appendix D.

(3) For extra information, please refer to Appendix F.

Typical Chemical Composition of Weld Metal (wt %) (Shielding Gas : CO_2)

C	Si	Mn	P	S	Cr	Ni	Mo
0.036	0.44	1.53	0.029	0.006	23.28	12.81	2.52

Typical Mechanical Properties of Weld Metal (Shielding Gas : CO_2)

Tensile Strength N/mm^2（kgf/mm^2）	Elongation %
590(60.2)	33

Size and Suggested Operating Range (DC+)

Diameter (mm)	F/H-fillet		V/OH	
	Amp	Volt	Amp	Volt
1.2	100~300	20~36	100~200	24~30
1.6	200~360	26~40	—	—