

GMAW Solid Wire for Stainless Steel

KMS-309LMo

Classification

AWS	A5.9/A5.9M	ER309LMo
JIS	Z3321	YS309LMo
EN	14343-A	G 23 12 2 L
YB	T5092	H03Cr24Ni13Mo2

Shielding Gas: Ar+1~2%O₂(CO₂)

Applications and Features

- (1) Weld metal is austenitic structure with 23%Cr-12%Ni-2%Mo.
- (2) Similar to 309 with the exception for the addition of 2.0 - 3.0% molybdenum to increase its pitting corrosion resistance in halide-containing environments.
- (3) Used to achieve a single-layer overlay with a chemical composition similar to that of a 316L stainless steel

Welding Position



Welding Instruction

- (1) Use Ar+1~2%O₂ for spray transfer and Ar+1~2%CO₂ for short-circuit transfer.
- (2) For welding dissimilar alloy, please refer to Appendix I.
- (3) For other instructions, please refer to Appendix B and F .

Typical Chemical Composition of Weld Metal (wt%)

C	Si	Mn	P	S	Cr	Ni	Mo
0.03	0.36	1.88	0.013	0.009	24.41	13.32	2.44

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation
N/mm ²	N/mm ²	%
620	440	39

Size and Suggested Operating Range (DC+)

Diameter (mm)	0.8	0.9	1.0	1.2	1.4	1.6	
Ar+1~2%CO ₂	Current (A)	40~120	60~140	80~160	100~210	-	-
	Voltage (V)	15~20	15~21	16~22	17~22	-	-
Ar+1~2%O ₂	Current (A)	160~210	170~260	180~280	200~300	210~320	220~330
	Voltage (V)	24~28	24~30	24~30	24~30	24~32	24~32