

SW-309MoL Cored

TYPE : Rutile

AWS A5.22 / ASME SFA5.22 E309LMoT1-1/-4
JIS Z3323 TS309LMo-FB1
EN ISO 17633-A-T 23 12 2 L P M/C 2

Applications

Main uses are for the applications of resistance to heat and corrosion and for the joining of stainless steels to mild or low alloy steels.

Characteristics on Usage

SW-309MoL Cored is designed for the welding of 22%Cr-12%Ni-2.5%Mo stainless steels. This wire has excellent crack resistance combined with good arc characteristics for the use of downhand and vertical up.

Notes on Usage

① Use with 100%CO₂ or Ar + 20~25% CO₂ gas.

Welding Position



1G (PA) 2F (PB) 3G (PF) 4G (PE)

Current

DC +

Shielding Gas

CO₂/Ar+20~25%CO₂

Typical Chemical Composition of All-Weld Metal (%) (Shielding Gas: 100% CO₂)

C	Si	Mn	P	S	Cr	Ni	Mo
0.03	0.70	1.20	0.025	0.010	22.5	12.5	2.5

Typical Mechanical Properties of All-Weld Metal (Shielding Gas: 100% CO₂)

TS MPa(lbs/in ²)	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
690 (100,000)	32	-20 (-4)	40 (30)

Approval

CWB, DNV, GL, NK

I Packing(Including Ball Pac)

Dia. (mm)	0.9	1.2	1.6	Spool(kg)	5	12.5	15
(in)	.035	.045	1/16	(lbs)	11	28	33

Sizes Available and Recommended Currents (Amp.)

Size mm (in)	0.9 (.035)	1.2 (.045)	1.6 (1/16)
F & HF	130~180	180~220	250~290
V-up,OH	100~140	120~160	-