# Supercored 309MoL

*TYPE : Rutile*

**AWS A5.22/ASME SFA5.22 E309LMoT0-1/-4**
**JIS Z3323 TS309LMo-FB0**
**EN ISO 17633-A-T 23 12 2 L R M/C 3**

## Applications

Supercored 309MoL is designed for applications of resistance to corrosion and for the joining of stainless to mild or low alloy steels.

## Characteristics on Usage

Supercored 309MoL which contains a high ferrite level in austenitic has excellent heat, corrosion and crack resistibility. It has a good stable arc and excellent slag removal properties.

## Notes on Usage

① Use with 100% $CO_2$ or Ar + 20~25% $CO_2$ gas.

| Welding Position | Current | Shielding Gas |
|---|---|---|
|  1G (PA) 2F (PB) | DC + | $CO_2$/Ar+20~25%$CO_2$ |

## Typical Chemical Composition of All-Weld Metal (%) (Shielding Gas: 100% $CO_2$)

| C | Si | Mn | P | S | Cr | Ni | Mo |
|---|---|---|---|---|---|---|---|
| 0.03 | 0.60 | 1.30 | 0.025 | 0.010 | 23.0 | 12.5 | 2.5 |

## Typical Mechanical Properties of All-Weld Metal (Shielding Gas: 100% $CO_2$)

| TS MPa(lbs/in²) | EL (%) | Temp. ℃ (℉) | CVN-Impact Value J (ft · lbs) |
|---|---|---|---|
| 600 (87,000) | 35 | -20 (-4) | 50 (37) |

## Approval

BV, DNV, GL, LR

## 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 | 120~180 | 150~220 | 240~300 |

FCAW