

AA 309L Mo

CATEGORY FCAW Flux-Cored

TYPE Rutile flux cored weldig wire for M21 and CO2

PROPERTIES This is a rutile flux cored wire which operates with very stable, spatter free arcs producing bright, smooth weld bead surfaces and self releasing slag. This wire deposits low carbon weld metal of about 23%Cr-13%Ni-2.3%Mo

CLASSIFICATION

AWS	A 5.22: E 309-LMoT0-1/-4
EN ISO	17633-A: T 23 12 2 L R C/M 3
DIN: W.Nr.	1.4459
DIN	8556: 23 13 2 L

SUITABLE FOR Cladding applications in case a AISI 316 is required in the first layer, suitable for dissimilar welding of steel to stainless steel, heat resistant up to 1050 degrees Celsius.

APPROVALS CE approved

WELDING POSITIONS:



C	Mn	Si	Cr	Ni	Mo	P	S	FS	FN
0.02	1.40	0.70	23.2	12.7	2.3	0.018	0.007	16.8	>18

MECHANICAL PROPERTIES

R _{PO,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V	
			-20°C	-40°C
540	700	30	42	

WELDING PARAMETERS PACKING

D (mm)	Welding Parameters		Packing	
	Current (A)	Voltage (V)	kg / spool	kg / pallet
1.2	120-190	20-34	15	

REDRYING TEMPERATURE 150°C / 24hr

GAS ACC. EN ISO 14175: M21, C1