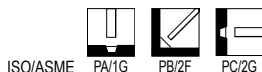


Cor-A-Rosta® 309MoL**CLASSIFICATION**

AWS A5.22 : E309LMoT0-1/-4
 ISO 17663-A : T 23 12 2 L R C/M 3

GENERAL DESCRIPTION

Gas shielded flux cored high CrNiMo alloyed wire electrode for downhand welding
 High Corrosion resistant deposit
 Specially developed for welding stainless steel to mild steel and buffer layers in cladding
 Maximum plate thickness in butt welds ~ 12 mm
 Suitable for repair welding in dissimilar joints and steels difficult to weld

WELDING POSITIONS**CURRENT TYPE**

DC +
 M21 : Mixed gas Ar+ (>15-25%) CO₂
 C1 : Active gas 100% CO₂
 Amount : 15-25 l/min

APPROVALS

Shielding gas	BV	DNV	GL	LR	TÜV
M21		308LMS	4550S		+
C1	UP	309MoLMS		SS/CMn	+

CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL

Shielding gas	C	Mn	Si	Cr	Ni	Mo	FN (acc.WRC 192)
M21 /C1	0.03	1.3	0.7	23	12.8	2.3	20

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J) +20°C
Required: AWS A5.22 ISO 17663-A			not required min. 350	min. 520 min. 550	min. 25 min. 25	
Typical values	M21/C1	AW	550	700	30	50

PACKAGING AND AVAILABLE SIZES

Diameter (mm)	1.2	1.6
Unit : 15 kg spool S300	X	X

Cor-A-Rosta® 309MoL - rev. EN 25

Cor-A-Rosta® 309MoL**MATERIALS TO BE WELDED**

Steel grades	EN 10088-1/-2	Mat. Nr	ASTM/ACI A240/A312/A351	UNS
Corrosion resistant cladsteels				
	X2 CrNiMo 17-12-2	1.4404	(TP)316L CF-3M	S31603 J92800
	X2 CrNiMo 18-14-3	1.4435	(TP)316L	S31603
	X2 CrNiMoN 17-11-2	1.4406	(TP)316LN	S31653
	X2 CrNiMoN 17-13-3	1.4429		
	X4 CrNiMo 17-13-3	1.4436		
	X6 CrNiMoTi 17-12-2	1.4571	316Ti	S31635
	X10 CrNiMoTi 17-3	1.4573	316Ti	S31635
	X6 CrNiMoNb 17-12-2	1.4580	316Cb	S31640

Welding dissimilar metals: mild steel or low alloyed steel to stainless CrNi or CrNiMo-steel up to max. thickness of 12 mm.
Build-up welding on mild and low alloyed steel

WELDING PARAMETERS, OPTIMUM FILL PASSES

Diameter (mm)	Welding positions		
	PA/1G	PB/2F	PC/G
1.2	100-250A	100-250A	100-200A

REMARKS/APPLICATION ADVICE

For positional welding, use Cor-A-Rosta P309MoL