

# M-309LMo

**AWS** ER309LMo  
**EN** 12072 G 2312 2L

FOR STAINLESS STEEL

## Typical applications

Suitable for dissimilar metal joint and underlaying on ferritic steels for overlaying stainless steel weld metals.

## Typical chemical composition of wire (%)

| C    | Si   | Mn   | Ni    | Cr    | Mo   |
|------|------|------|-------|-------|------|
| 0.02 | 0.45 | 1.45 | 14.50 | 23.20 | 2.61 |

## Typical mechanical properties of all-weld-metal

| Shielding Gas       | T · S<br>N/mm <sup>2</sup> {kgf/mm <sup>2</sup> } | El<br>(%) | IV<br>(J)             |
|---------------------|---------------------------------------------------|-----------|-----------------------|
| Ar+2%O <sub>2</sub> | 660 {67}                                          | 33        | 0.°C: 92<br>-40°C: 89 |

## Package

| Dia. (mm)     | 0.8         | 0.9 | 1.0 | 1.2           | 1.4 | 1.6 |
|---------------|-------------|-----|-----|---------------|-----|-----|
| Spool. (kg)   | 5, 12.5, 20 |     |     |               |     |     |
| Pailpack.(kg) | 200, 250    |     |     | 200, 250, 300 |     |     |

Approved by