

ROYAL – ER 309 Mo (ER 309 Mo)

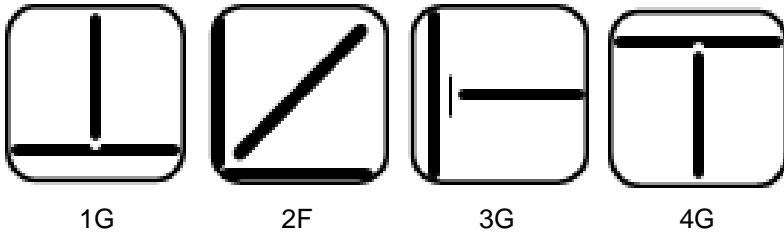
AWS / SFA 5.9 ER 309 Mo

Applications

This wire rod is suitable for welding of dissimilar steel combination, such as AISI 304, 316, clad steel or the overlay of carbon steel. The weld metal reduces inter granular corrosion where severe corrosion condition exist requiring high alloy weld metal.

Characteristics on Usage

The composition of this rod is the same that deposited by E309Mo electrodes except for the addition of Molybdenum and a small reduction in the Carbon limit. The weld metal is free from porosity and any welding defects. It is used for welding 316 clad steel or for the overlay of Carbon steels.

Welding Positions

1G

2F

3G

4G

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo
0.12Max	1.00 – 2.50	0.30 – 0.65	0.03 Max	0.03 Max	23.0 – 25.0	12.0– 14.0	2.0 –

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	ELONGATION (L = 4d) %
550	30

Packing

Each Packets content 5 kg of Wire Rods having length 500 mm. 1000mm