

ROYAL – ER 309LMo (ER 309 L Mo)

AWS / SFA 5.9 ER 309 L 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 E309 L Mo 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 316L clad steel or for the overlay of Carbon steels.

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo
0.030 Max	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) %
520	30

Packing

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