



Cromatig 309MoL

GTAW - TIG
Stainless Steel

Date: 11/16/2014
Revision: 8

Description:

Cromatig 309MoL deposits a 23% Cr / 12% Ni / 2.5% Mo austenitic stainless steel weld metal. The high alloy content and ferrite level enable the weld metal to tolerate dilution from dissimilar and difficult-to-weld materials without hot cracking.

APPLICATIONS:

- Buffer layers on mild and low alloy steels prior to overlaying with Cromarod 316L.
- Joining of 316L clad steels and dissimilar joints between stainless and mild or medium carbon steels.
- Joining of medium carbon hardenable steels.

Welding current:

DC-

Wire composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min		0,30	1,0			21,0	12,0
Typical	0,015	0,4	1,5	0,025	0,002	21,5	14,5
Max	0,020	1,00	2,5	0,030	0,020	25,0	15,5

	Mo	Cu	N
Min	2,0		
Typical	2,6		0,06
Max	3,0	0,3	

Shielding gas:

I1, Ar 99.99%, 6-12 l/min

Ferrite content:

FN 12

Corrosion resistance

The corrosion resistance after surfacing carbon steels with two layers of Cromatig 309 MoL is about the same as for 316L material.

Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min							
Typical	0,02	0,4	1,6	0,015	0,015	21,5	14,5
Max							

	Mo
Min	
Typical	2,6
Max	

Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Rp0.2%:	≥ 350 MPa	400 MPa
Tensile Strength, Rm:	≥ 520 MPa	600 MPa
Elongation, A5	≥ 30%	40%
Impact energy, CV:		20 °C • 140 J

Classification:

EN ISO 14343 W 23 12 2 L
AWS A5.9 ~ER309LMo

Approvals:

Product data:

Ø x Length mm	Packet weight	Product code
1,2 x 1000	5 kg	98261012
1,6 x 1000	5 kg	98261016
2,0 x 1000	5 kg	98261020
2,4 x 1000	5 kg	98261024
3,2 x 1000	5 kg	98261032
2,0 x 500	4 x 1 kg	98261520
2,4 x 500	4 x 1 kg	98261524

Note

All 500 mm rods are colour coded

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