KT-309LMo

Classification

AWS A5.9/A5.9M ER309LMo

Applications and Features

(1) Weld metal is austenite structure with 23%Cr-13%Ni-2%Mo.

(2) Better strength and corrosion resistance at high temperature than 309LSi due to Mo content.

(3) Good crack resistance due to moderate ferrite content.

(4) It is suitable for welding dissimilar metals (carbon steel and stainless steel).

Typical Chemical Composition (wt%)

C	Si	Mn	P	S	Cr	Ni	Mo
0.019	0.44	1.84	0.009	0.011	23.81	12.95	2.52

Typical Mechanical Properties of Weld Metal (Shielding Gas : Ar)

Tensile Strength MPa	Yield Strength MPa	Elongation %
610	435	41

Sizes and Suggested Operating Range

Size mm	Current A	Gas Flow L/min	Shielding Gas
1.6	75- 100	25	Ar
24	150-200	25	Ar

Diam.	5 kg Tube
1.6mm	KT309Lmo16
2.4mm	KT309Lmo24

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