

DATA SHEET N. 3001

DAIKO 309LMo

MIG - TIG - SAW

Description / Alloy type: Solid wire 23%Cr-13%Ni-2.5%Mo (309Mo) austenitic stainless steels.

Specifications: **AWS A5.9** **EN ISO 14343-A** **EN ISO 14343-B**
(ER309LMo) 23 12 2 L (SS309LMo)

Applications: These consumables are mainly used under high dilution conditions, particularly dissimilar welds between stainless and CMn steels. Also overlays on CMn steel or low alloy steel and for joining 316L clad plate. There are no comparable base materials.

Composition:
(weight %)

%	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	FN
Min	-	1.0	0.30	-	-	21	12.0	2.0	-	5
Max	0.030	2.5	0.65	0.020	0.030	25	15.0	3.0	0.3	20
Typ	0.015	1.7	0.50	0.005	0.015	22	14.5	2.6	0.2	10

Typical parameters:

	TIG	MIG
Shielding	Argon	Ar + 2% O ₂ Ar-He + <3% CO ₂
Current	DC-	DC+
Diameter	2.4 mm	1.2 mm
Parameters	100A, 12V	260A, 26V

All-weld proprieties:

As welded	Typ. TIG
Tensile strength [MPa]	610
0.2% proof stress [MPa]	440
Elongationon 4d [%]	35
Impact Energy 20°C [J]	>90
Hardness HV	205/220

Complementary products: SMAW rutile / basic electrode (AWS A5.4 E309LMo-17 / E309LMo-15)
FCAW wire (AWS A5.22 E309LMoT0-1/4 / E309LMoT1-1/4)