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SISTEMA DI GESTIONE
CERTIFICATO DA ICIM
UNI EN ISO 9001:2015

DATA SHEET No. S122

DAIKOW 309LMo

MIG – TIG – SAW

Description / Alloy type: 23%Cr – 13%Ni – 2,5%Mo (309LMo) austenitic stainless steel solid wire.

Specifications:

AWS A5.9	**EN ISO 14343-A**	**Wr. n.**
(ER309LMo)	23 12 2 L	(1.4459)

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. Also as a buffer layer prior to hardfacing with chromium carbide and cobalt alloys.
There are no comparable base materials.

Composition: (weight %)

%	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	FN
Min	-	1.0	0.30	-	-	21.0	11	2	-	5
Max	0.03	2.5	0.65	0.02	0.030	25.0	15.5	3.5	0.30	20
Typ	0.01	1.5	0.40	0.01	0.015	21.4	15	2.6	0.15	10

Typical parameters:

	TIG	MIG	SAW
Shielding	Argon	Ar + 2% O_2	Daikoflux
Current	DC-	DC+	DC+
Diameter	2.4 mm	1.2 mm	2.4 mm
Parameters	100A, 12V	260A, 26V	350A, 28V

All-weld proprieties:

As welded	Typical
Tensile strength [MPa]	600
Yield strength [MPa]	440
Elongation [%]	35
Impact Energy +20°C [J]	>80

Complementary products:
SMAW electrode (AWS A5.4 E309MoL-15/16/17)
FCAW wire (AWS A5.22 E309LMoT0-1/4 / E309LMoT1-1/4)
ESW strip (A5.9 ~EQ309L)