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[info@daikowelding.com](mailto:info@daikowelding.com)[www.daikowelding.com](http://www.daikowelding.com)**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 <sub>2</sub> | 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)