

# GETIG 309Mo

## IDENTIFICATION

Getig 309Mo, ER 309Mo

## CLASSIFICATION

AWS/SFA 5.9 ER309Mo

## DESCRIPTION

Solid wire deposits a 24 % Cr / 13 % Ni / 2.5 % Mo austenitic stainless steel weld metal with a ferrite content about FN 16. The high alloy level and high ferrite content enables the weld metal to tolerate dilution from carbon and low alloy steels without hot cracking.

## CHEMICAL ANALYSIS (RANGE) %

C	Mn	Si	Cr	Cu	Ni	Mo	S	P	Mo
0.12 max	1.0 - 2.50	0.30 - 0.65	23.0 - 25.0	0.50 max	Dec-14	0.50 max	0.03 max	0.03 max	2.0 - 3.0

## MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	EL (%) (L=4D)	CVN Impact Value	
		Temp	Joules
580 - 680	35 - 45	0°C	50 - 100

## TYPICAL APPLICATIONS

- Buffer layer on mild steel or low alloy steels.
- Joining of clad steels and dissimilar joints between stainless and mild or low alloy steels. Joining of ferrite-martensitic stainless steels.
- Welding of similar composition, 309Mo type stainless steel.
- Joining type 304/304L, 347, 321, 316/316L and duplex stainless steel to mild and low alloy steels.

**SHIELDING GAS :** Argon, 99.99%, 6-12 l/min

**WELDING CURRENT :** DC ( - )

## CORROSION RESISTANCE

Good resistance to general and intergranular corrosion. Also good resistance to oxidising acids and cold reducing acids.

## PACKING PARAMETERS

Size (mm)	Length (mm)	Packing / Packet (kg)	Packing / Box (kg)
1.6	1000	5	5 x 4 = 20
2	1000	5	5 x 4 = 20
2.40 / 2.50	1000	5	5 x 4 = 20

