

# GFC 309LMo

## IDENTIFICATION

GFC 309LMo, E309LMoT1-1/-4

## CLASSIFICATION

AWS A5.22 / ASME SFA5.22 E309LMoT1-1/-4

JIS Z3323YF309MoLC

## DESCRIPTION

GFC 309LMo is design for the welding of 22% Cr - 12% Ni - 2.5% Mo stainless steel. The wire has excellent crack resistance combined with good arc characteristics of the use of downhand and vertical up.

## WELD METAL ANALYSIS (RANGE) %

C	Si	Mn	P	S	Cr	Ni	Mo	Cu
0.04 max	1.0 max	0.5 - 2.5	0.03 max	0.03 max	21 - 25	Dec-16	02-Mar	0.10 max

## MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	EL (%) (L=4D)	CVN Impact Value	
		Temp	Joules
525 min	30 min	20°C	45

## TYPICAL APPLICATIONS

Typical for the application of resistance to heat and corrosion and for the joining of stainless steels to mold or low alloy steels.

**SHIELDING GAS :** with 100% CO<sub>2</sub> or Ar + 20 - 25% CO<sub>2</sub> gas.

**CURRENT CONDITION(AMPS) :** DC ( + )

## CURRENT PARAMETERS

Size (mm)	Welding position F & HF	Welding position V-up, OH	Weight / Spool (kg)
1.2	180 ~ 220	120 ~ 160	15
1.6	250 ~ 290	Not Recommended	15