

BASINOX 309LMo

TOP FEATURES

- Basic MMA electrode suitable for the welding of stainless steels type AISI 309.
- Particularly suitable for the welding of dissimilar steels (stainless steels to carbon steels).
- Weld deposit carbon content is 0.04% max
- Service temperature up to +1000°C, at elevated temperatures the Mo content improves the creep properties.
- Excellent weldability with a spatter free arc
- Self-releasing slag, efficiency 100%

CLASSIFICATION

AWS A5.4 E309LMo-15
EN ISO 3581-A E 23 12 2 L B 22

CURRENT TYPE

DC+

WELDING POSITIONS

All position, except vertical down

APPROVALS

TÜV
+

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Si	P	S	Cr	Ni	Mo		Ferrite
0.025	1.4	0.4	≤0.030	≤0.025	22.5	13	2.5		5-15

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Required	Condition*	0.2% Proof strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) +20°C
AWS A5.4	AW	not specified	min. 520	min. 30	not specified
EN ISO 3581-A	AW	min. 350	min. 550	min. 25	not specified
Typical values	AW	380	600	32	50

*AW: As-welded

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5x300	45-70
3.2x350	65-120
4.0x350	115-140

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 300	VPMD	100	1.8	W100287985
3.2 x 350	VPMD	60	2.2	W100287986
4.0 x 350	VPMD	40	2.1	W100287987

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.