

ER309Mo

SAW

SOLID 309Mo WIRE FOR SAW

PRODUCT DESCRIPTION

Solid wire for submerged arc welding.

CLASSIFICATIONS

AWS A5.9M	[ER309LMo]	Nearest classification
EN ISO 14343-A	23 12 2 L	
EN ISO 14343-B	[SS309LMo]	Nearest classification

ASME IX QUALIFICATION

QW432 F-No 6

QW442 A-No 8

Most relevant F & A No because wire does not conform to AWSA5.9

CHEMICAL COMPOSITION (WELD METAL WT %)

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	FN
Min.	--	1.0	0.30	--	--	21.0	11.0	2.0	--	5
Max.	0.03	2.5	0.65	0.02	0.030	25.0	15.5	3.5	0.3	20
Typical	0.015	1.7	0.5	0.005	0.015	22	14.5	2.7	0.2	10

ALL-WELD MECHANICAL PROPERTIES

As welded	Typical
Tensile strength [MPa]	
0.2% proof strength [MPa]	
Elongation (%) 4d	
5d	
Reduction of area %	
Impact ISO-V[J] +20°C	
Hardness cap/mid [HV]	

TYPICAL OPERATING PARAMETERS

Flux	Current	Diameter (mm)	Parameters
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**CSB also suitable.

Diameter (mm)	Weight (kg)	Packaging	Item number
2.4	25	B415	SAER309MO-24