

ESAB 309Mo

ESAB 309Mo is a basic coated, over-alloyed stainless steel electrode giving a weld deposit of 23Cr-13Ni-2.5Mo type, for welding stainless steels to other types of steels, where better toughness is required.

Specifications

Classifications	SFA/AWS A5.4 : E309Mo-15
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Welding Current	DC+
Ferrite Content	15-24 FN
Alloy Type	Austenitic Cr-Ni-Mo
Coating Type	Basic

Typical Tensile Properties

Condition	Conditional Statement	Yield Strength	Tensile Strength	Elongation
AWS				
As Welded	As welded	520 MPa	620 MPa	32 %

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo
0.06	0.80	0.80	13.00	24.00	2.50

Deposition Data

Diameter	Current
2.5 x 350.0 mm	60-100 A
3.15 x 350.0 mm	80-120 A
4.0 x 350.0 mm	120-170 A