

## ESAB 309LMo

ESAB 309LMo is a low carbon basic coated all positional stainless steel electrode, giving an austenitic weld deposit of 23Cr-13Ni-2.5Mo type for welding stainless steels to unalloyed and low alloyed steels. The weld metal has excellent resistance to corrosion and oxidation at elevated temperatures up to 1100°C.

Specifications	
Classifications	SFA/AWS A5.4 : E309LMo-15

Welding Current	DC+
Ferrite Content	15-22 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	500 MPa	600 MPa	34 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
AWS		
As Welded	-46 °C	30 J

Typical Weld Metal Analysis %					
C	Mn	Si	Ni	Cr	Mo
0.025	0.70	0.85	13.30	23.00	2.30

Deposition Data	
Diameter	Current
2.5 x 350.0 mm	60-90 A
3.15 x 350.0 mm	80-120 A
4.0 x 350.0 mm	100-170 A