

# BETANOX 309Mo PLUS

AWS A/SFA 5.4 E309Mo-17

STAINLESS STEEL (Dissimilar Steel Welding)

## CLASSIFICATION:

ISO 3581-B  
ES 309Mo-17

IS 5206  
E 23.12.2 R36

## KEY FEATURES:

- Acid-Rutile based coating
- Deposit is 23/12/2.5Mo type
- High ferrite content ensures maximum cracking resistance
- Easy slag removal
- Mo addition provides high strength and corrosion resistance
- Excellent corrosion and oxidation resistance upto 1100°C
- Radiographic quality weld deposit

**APPROVALS:** CE

## TYPICAL APPLICATIONS:

- Welding of AISI 309 Mo type steels
- Dissimilar joints between 316 type and low alloy or carbon steels
- Buffer layer on low alloy and carbon steels before deposition of 316 type weld metal


## TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

| C    | Mn  | Si  | Cr   | Mo  | Ni   |
|------|-----|-----|------|-----|------|
| 0.04 | 0.6 | 0.8 | 22.9 | 2.2 | 13.5 |

## MECHANICAL PROPERTIES OF ALL WELD METAL:

|               | Condition | UTS, MPa | EL%    | Ferrite No. |
|---------------|-----------|----------|--------|-------------|
| Typical       | As Welded | 630      | 37     | 14          |
| Specification |           | 550 min  | 30 min | 16 max      |

## PARAMETERS - PACKING DATA:

|   |   |  |                                      |
|---|---|--|--------------------------------------|
| <b>Ø x L, mm</b><br>2.0 x 300<br>2.5 x 350<br>3.15 x 350<br>4.0 x 350 | <b>Amperage, A</b><br>50-75<br>80-100<br>110-140<br>150-180 |  <b>AC (70 OCV) /DCEP</b> | Flat butt and fillet welds only<br>→ |
| <b>REDRYING CONDITION:</b><br>250-300°C for minimum 1 hr.             |   |  |                                      |

Available in Standard carton packing of 10 kg box containing 5 cartons of 2 kgs each.

## EQUIVALENT:

| GMAW          | GTAW          |
|---------------|---------------|
| Miginox 309Mo | Tiginox 309Mo |