



BETANOX 309Mo PLUS

STAINLESS STEEL (Dissimilar Steel Welding)

AWS A/SFA 5.4 E309Mo-17

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 309Mo 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%
Typical	As Welded	630	37
Specification		550 min	30 min

PARAMETERS - PACKING DATA:

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

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