



BETANOX 309Mo PLUS

STAINLESS STEEL (Dissimilar Steel Welding)



A Stainless steel Electrode depositing 23/12/2.5 Mo alloy

CLASSIFICATION : ISO 3581-A

AWS A/SFA 5.4

IS 5206

ES 309Mo-17

E 309Mo-17

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

WELDING POSITION :



AC (70 OCV) /DCEP

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

REDRYING CONDITION : 250-300°C for minimum 1 hr.

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Cr	Ni	Mo	Mn
	0.06	23.5	12.8	2.4	1.7
Specification	0.12 max	22.0-25.0	12.0-14.0	2.0-3.0	0.5-2.5
	Si	P	S	Cu	
	0.6	0.02	0.02	0.2	
Specification	1 max	0.04 max	0.03 max	0.75 max	

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	EL%	Ferrite No.
Typical	As Welded	630	37	14
Specification		520	30 min	12-15

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Wt./Carton, Kg	Cartons/Box	Net wt./Box, Kg
2.5 x 350	50-75	2	5	10
3.15 x 350	80-100	2	5	10
4.0 x 350	110-140	2	5	10

EQUIVALENT : GMAW wire: Miginox 309Mo

GTAW filler: : Tiginox 309Mo