

BETANOX DMo

AWS A/SFA 5.4 E309Mo-16

STAINLESS STEEL (Dissimilar Steel Welding)

CLASSIFICATION:

ISO 3581-B
ES 309Mo-16

IS 5206
E 23.12.2 R26

KEY FEATURES:

- Rutile coated electrode
- High ferrite content ensures maximum cracking resistance
- Mo addition provides high strength and corrosion resistance
- Deposit is 23/12/2.5Mo type
- Excellent corrosion and oxidation resistance upto 1100°C
- Suitable for all position
- Radiographic quality welds

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
0.05	1.2	0.5	23.5	2.2	12.7

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%	Ferrite No.
Typical	As Welded	650	36	14
Specification		550 min	30 min	16 max

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A		
2.0 x 300	50-75	 AC (70 OCV) /DCEP	All Positions, except vertical Downwards
2.5 x 350	80-100		
3.15 x 350	110-140		
4.0 x 350	150-180		
		REDRYING CONDITION: 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