



MIGINOX 309Mo

GMAW STAINLESS STEEL

AWS A/SFA 5.9 ER309Mo

CLASSIFICATION:

EN ISO 14343-B
SS 309Mo

KEY FEATURES:

- A 23 Cr/12Ni/Mo SS solid wire
- High ferrite content ensures maximum cracking resistance
- Excellent corrosion & oxidation resistance up to 1100°C
- Mo addition provides high strength and pitting corrosion resistance
- 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 BARE SOLID WIRE, Wt %:

C	Mn	Si	Cr	Ni	Mo
0.04	1.75	0.4	23.2	13.5	2.3

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%
Typical	As Welded	620	37

PARAMETERS - PACKING DATA:

Ø, mm	Kg/Spool	 DCEP STORAGE / HANDLING : Keep dry and follow handling instructions mentioned on the box	All Positions 
0.8	12.5		
1.2	12.5		
1.6	12.5		

Shielding Gas	Gas Flow Rate, LPM
98Ar/2O ₂ or Ar/1-5CO ₂	15-22