



GMAW / GTAW STAINLESS STEEL

MIGINOX 309Mo / TIGINOX 309Mo

23Cr/12Ni/2.5Mo TYPE STAINLESS STEEL SOLID WIRE



CLASSIFICATION : AWS A/SFA 5.9

APPROVALS :

Miginox 309Mo: ER309Mo -
Tiginox 309Mo: ER309Mo -

KEY FEATURES :

- A 23Cr/12Ni type stainless steel 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

WELDING POSITION :



GMAW: DCEP
GTAW: DCEN

Shielding Gas	Gas Flow Rate, LPM	Stickout, mm
GMAW: 98Ar/2O ₂ or Ar/1-5CO ₂	15-22	10-20
GTAW: Ar	10-15	-

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

STORAGE / HANDLING :

Keep dry and follow handling instructions mentioned on the box

CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt% :

	C	Mn	Si	Cr	Ni	Mo	S	P
Specification	0.12 max	1.0-2.5	0.30-0.65	23.0-25.0	12.0-14.0	2.0-3.0	0.03 max	0.03 max

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	EL%
Specification	As Welded	550 min	30 min

Mechanical properties will vary with the type of shielding gas used.

PACKING DATA :

Miginox 309Mo	Ø, mm		Kg/Spool	
	0.8		12.5	
	1.2		12.5	
	1.6		12.5	
	2.0		12.5	
Tiginox 309Mo	Ø x L, mm	Primary Box, Kg	No. of Primary Boxes	Net Wt. of Carton, Kg
	1.6 x 1000	5	4	20
	2.0 x 1000	5	4	20
	2.5 x 1000	5	4	20

EQUIVALENT :

SMAW Electrode: **Betanox DMo**