

Classifications

EN ISO 14343-A	AWS A5.9 / SFA-5.9
S 23 12 2 L	ER309LMo (mod.)

Characteristics and typical fields of application

Solid wire for submerged arc welding, and is a Mo-alloyed wire, type ~309LMo for dissimilar joints of un-alloyed and stainless steels and for cladding on low-alloyed steels. The all-weld-metal ensures a high resistance against cracking and is also suitable for welding of high strength steels. When used for surfacing the composition is more or less equal to that of ASTM 316 from the first run. Corrosion resistance of all weld metal is comparable but slightly better than 316L. Structure: Austenit with 5 – 10 % Ferrit. Scaling temperature: 950 °C (air).

Typical analysis of the wire

	C	Si	Mn	Cr	Ni	Mo	FN
wt.-%	0.02	0.35	1.5	21.5	15.0	2.7	8

Typical fluxes to combine

Process	Name	EN ISO 14174
SAW	Marathon 805 (Avesta Flux 805)	S A AF 2 DC

Packaging

Size(s) in mm	Type	Weight
2,4	basket spool	25 kg
3,2	basket spool	25 kg
4,0	basket spool	25 kg

Other sizes and coil weights on request.

