

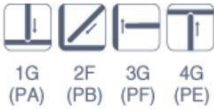
## E309LMo-16

AWS A5.4 E309LMo-16  
 ISO3581-A-E23 12 2 LR  
 GB/T 983 E309LMo-16

### Description:

A super-low carbon Cr22Ni12Mo2 stainless steel electrode ,the carbon content of its deposit metal is  $\leq 0.04\%$ . With excellent operation properties and pores resistance, the proper Mo element improves corrosion and crack resistance. Used to weld similar composition super low carbon stainless steels and dissimilar steel structures.

### Welding Position:



### Diameters:

2.5mm, 3.2mm, 4.0mm, 5.0mm.

### Typical Mechanical Properties:

Tensile strength(MPa):	550
Yield strength(MPa):	--
Elongation(%):	41

### Typical Chemical Composition:

C	Mn	P	S	Si	Ni	Cr	Mo	Cu
0.019	0.82	0.018	0.003	0.65	12.8	23.4	2.63	0.30

### Welding Current:(AC/DC±)

Diameter(mm)	2.5	3.2	4.0	5.0
Current/A	F/H 60-80	80-120	100-150	140-180
Current/A	V/OH 40-70	60-100	80-130	-

### Note:

- 1.The electrodes should be baked 1 hours in 300-350℃ before using.
- 2.Welding in short arc,and swing scope should not excess 2.5 times of the electrode diameter.