KS-309Mo

Type of coating: Lime titania type

Classification

AWS	A 5.4	E309 Mo -16
JIS	Z3221	ES309Mo-16
EN	3581-A	—
GB	T 983	E309Mo-16

Applications and Features

(1) It provides better strength, crack and corrosion resistance than KS-309 at high temperature due to additional Mo content.

(2) It is suitable for welding dissimilar metals (carbon steel and low carbon stainless steel), such as carbon steel and AISI 316.

Welding Position

All Positions

Welding Instruction

(1) Please refer to Appendix H for re-drying instructions.

(2) For welding dissimilar metals, please refer to Appendix I.

(3) For other instructions and information, please refer to Appendix F.

Typical Chemical Composition of Weld Metal (wt. %)

C	Si	Mn	P	S	Cr	Ni	Mo
0.065	0.40	1.54	0.013	0.009	23.81	12.91	2.51

Typical Mechanical Properties of Weld Metal

Tensile Strength N/mm^2 (kgf/mm^2)	Yield Strength N/mm^2 (kgf/mm^2)	Elongation %
620(63.2)	440(44.9)	40

Size and Suggested Operating Range (AC or DC+)

Diameter x Length (mm)		2.0x250	2.6x300	3.2x350	4.0x350	5.0x350
Amp	F/H-Fillet	35~55	50~85	80~120	100~150	140~200
	V-up/OH	30~50	45~85	70~110	90~135	—