

## Stick Electrode for Stainless Steel

# KS-309MoL

### Classification

AWS	A 5.4	E309LMo-16
JIS	Z3221	ES309LMo-16
EN	3581-A	E 23 12 2 L R
GB	T 983	E309MoL-16

Type of coating: Lime titania type

### Applications and Features

- (1) It provides better corrosion than KS-309Mo due to low carbon content.
- (2) It is suitable for welding dissimilar metals (carbon steel and low carbon stainless steel), such as carbon steel and AISI 316L.

### 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
0.030	0.40	1.80	0.013	0.009	23.72	12.87	2.52

### Typical Mechanical Properties of Weld Metal

Tensile Strength N/mm <sup>2</sup> (kgf/mm <sup>2</sup> )	Yield Strength N/mm <sup>2</sup> (kgf/mm <sup>2</sup> )	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	—