PRODUCT DATA SHEET

TIG WIRE - PROWELD - 309LMo/ (1.4459)

Classification: AWS / ASME – A/ SFA 5.9 ER 309LMo
BS EN 14343: W 23.12. 2L

Typical Applications:

Proweld 309LMo is Mo alloyed 23 Cr 12 Ni wire primarily used for surfacing of low alloy steels & dissimilar welding between mild steel /ferritic steels to austenitic stainless steels. The high alloy content and higher ferrite content offers a ductile and crack resistant weldment. Recommended for dissimilar joints

Wire Composition: (%)

	C	Mn	Si	Cr	Ni	S	P	Mo
min	-	1.0	--	23	11	-	-	2.0
max	0.03	2.5	0.65	25	15.5	0.02	0.03	3.0

Mechanical properties (Typical as Weld):

Tensile Strength	620N/mm²
Yield Strength	400 N/mm²
Elongation A5	35%
Impact energy(20° C)	130J
-196°C	55 J
Hardness	200 BHN

Ferrite content:

Ferrite Number about 12 – WRC-92

Welding Parameters

The information will be provided on request.

Shielding Gas:

I1 Pure Argon 5-10 L/min
M13 Argon+1-3% $O_{2\,5,}$ 5-10 L/min

Corrosion resistance:

Superior to type 308L. When surfacing on mild steel a corrosion resistance equivalent to ASTM 316 is obtained at the first run.
The PRE (Pitting Resistance Equivalent) is about 30

Packaging Detail:

Diameter :	0.8,1.0.1.20 ,1.60, 2.0, 2.40, 3.20, 4.0 mm*
Length :	1000 mm (36")
Packing :	5 Kgs in Spiral Tubes/Plastic, then in a master Carton of 25 Kg(5x5)**

* Also available in AWS standard diameters

Marking:

Both ends embossed with grade and diameter for the diameter >=1.60mm

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