

PRODUCT DATA SHEET

MIG WIRE - PROWELD - 309LMo/ (1.4459)

Classification: AWS / ASME – A/ SFA 5.9 ER 309LMo
BS EN 14343: G 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

Welding Parameters

The welding parameters such as Current, Voltage, and Welding Speed depend on applications, section thickness etc for each wire size. This information will be provided on request.

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

Shielding Gas:

M12 Argon+2% CO₂, 14-20 L/min
M13 Argon+1-3% O₂, 14-20 L/min

Mechanical properties (Typical as Weld):

Tensile Strength	620N/mm ²
Yield Strength	400 N/mm ²
Elongation A5	35%
Impact energy(20° C)	130J
-196°C	55 J
Hardness	200 BHN

Corrosion resistance:

Superior to type 308L. When surfacing on mild steel a corrosion resistance equivalent to ASTM 316 is obtained at the first run.

Packaging Detail:

Diameter : 0.80, 1.00, 1.20 , 1.60 mm *

Packing ** : 12.5Kg (25 lbs), 15Kg (30 – 33lbs)
Layer wound plastic spools i.e. SD300, Metallic basket (K300).
5Kg (10lbs) layer wound plastic spools i.e. SD200.
1Kg (2lbs) layer wound plastic spools i.e. SD100.
Drum pack 100 kgs and 250 kgs (0.80, 1.00, 1.20mm)

*Also available in AWS standard diameters.

Ferrite content:

Ferrite Number about 12 – WRC-92