

# ES TIG 309MoL

GTAW  
W 23 12 2 L

**ESWECO**  
*The Art of Welding*

## Description

Bare, corrosion-resistant rod of the "309LMo" type. ES TIG 309MoL is used for the overlay welding of unalloyed and low-alloyed steels and for welding dissimilar steels such as 316L to unalloyed and low-alloyed steels when Mo is essential.

## Current

DC (-)

## Classifications

EN 12072                      W 23 12 2 L

## Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Cu
<0.03	0.5	1.6	22.0	14.8	2.7	<0.3

## Typical mech. Properties all weld metal

Yield stress, MPa	400
Tensile strength, MPa	600
Elongation, %	40

## Charpy V

Test temps, °C	Impact values, J
+20	140

## Welding parameters

Diameter, mm	Length, mm	Weight of rods/box, kg
1.6	1000	5.0
2.0	1000	5.0
2.4	1000	5.0
3.2	1000	5.0