

ES 309MoL-17

SMAW

ESWECO
The Art of Welding

Type Acid-rutile

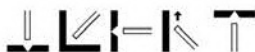
E309MoL-17

Description

ES 309MoL-17 is an over-alloyed, stainless-steel electrode for use as a buffer layer when welding acid-resistant clad steels and stainless steels to othertypes of steel. ES 309MoL-17 has outstanding welding properties on both AC and DC. The electrode can be used in all positions apart from vertical down.

Current

DC+, AC OCV 55 V



Classifications

EN 1600	E 23 12 2 L R 3 2
SFA/AWS A5.4	E309MoL-17
Werkstoff Nr.	1.4459

Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Cu
<0.03	0.7	0.9	23.0	13.0	2.8	<0.3

Typical mech. Properties all weld metal

Yield stress, MPa	510
Tensile strength, MPa	610
Elongation A5, %	32

Charpy V

Test temps, °C	Impact values, J
+20	50
-20	>32

Ferrite content FN 12-22

Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V
2.5	300	50-90	29
3.2	350	90-120	28
4.0	350	130-180	31
5.0	350	160-240	30