

TIGINOX 309Mo / MIGINOX 309Mo

Classification

AWS A/SFA 5.9 : ER 309Mo

Characteristic

This filler is used for TIG/MIG welding of molybdenum containing high alloy and un-alloyed steels. The presence of molybdenum improves tensile strength and corrosion resistance.

Typical Application

Suitable for welding of stainless steel type AISI 309 series, 316 type clad steels as well as dissimilar metals such as molybdenum containing austenitic stainless steel to carbon steel etc.

Wire Chemistry

C	S	P	Mn	Si	Cr	Ni	Mo	Cu
0.12 max	0.03 max	0.03 max	1.0-2.5	0.30-0.65	23.0-25.0	12.0-14.0	2.0-3.0	0.75 max

Properties of weld metal with 100% Argon gas shielding Current Condition: TIG : DC (-) MIG : DC (+)

Classifications:

All Weld Mechanical Properties As welded condition

Yield strength MPa	460	CVN Impact value
UTS MPa	640	
Elongation % (L=4xd)	38	90 J at (-60)°C
The chemistry and mechanical properties of the weld metal will vary with the type of shielding gas used.		

Packing Specifications

Supplied in D 300 plastic spools - layer wound / Weight - 12.5 Kg

Each plastic spool is sealed in a polyethylene bag and then packed in a corrugated box which is shrink-wrapped.

Packing Specifications for MIGINOX 309Mo

Dia., mm	0.8	1.2	1.6	2.0
Net wt per spool,kg	12.5	12.5	12.5	12.5

Packing Data for TIGINOX 309Mo

Dia., mm	1.0	1.2	1.6	2.0	2.5
Length,mm	1000	1000	1000	1000	1000
Net wt per tube,kg	5	5	5	5	5
No of Plastic Tubes per Box	4	4	4	4	4
Net wt,Box,kg	20	20	20	20	20



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