



Product Data Sheet

W 'Tungsten inert gas arc welding'

OK Tigrod 309MoL

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REASON FOR ISSUE

Mechanical data updated.

GENERAL

Bare corrosion resisting rod of 309LMo" type .

OK Tigrod 309MoL is used for overlay welding of unalloyed and low alloyed steels and for welding of dissimilar steels such as 316L to unalloyed and low alloyed steels when Mo is essential.

Shielding Gas: I1 (EN ISO 14175)

Alloy Type: Austenitic (with approx. 8% ferrite) "309LMo",
22 % Cr - 15 % Ni - 3 % Mo - Low C

CLASSIFICATIONS Wire Electrode

EN ISO 14343-A W 23 12 2 L
SFA/AWS A5.9 ER309LMo (mod)

APPROVALS

DNV 309MoL

APPROVAL COMMENT

Valid for lotnumbers starting with PV

CHEMICAL COMPOSITION

Wire/Strip (%)

	Min	Max
C		0.02
Si	0.25	0.65
Mn	1.2	2.0
P		0.025
S		0.020
Cr	21.0	23.0
Ni	14.0	15.5
Mo	2.4	3.1
Cu		0.20
Others tot		0.50

MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal

Properties	As welded	
	Min	Typ
Rp0.2 (MPa)	350	500
Rm (MPa)	550	610
A5 (%)	25	30
Charpy V at 20°C (J)		130