PREMIARC™ DW-309MoL

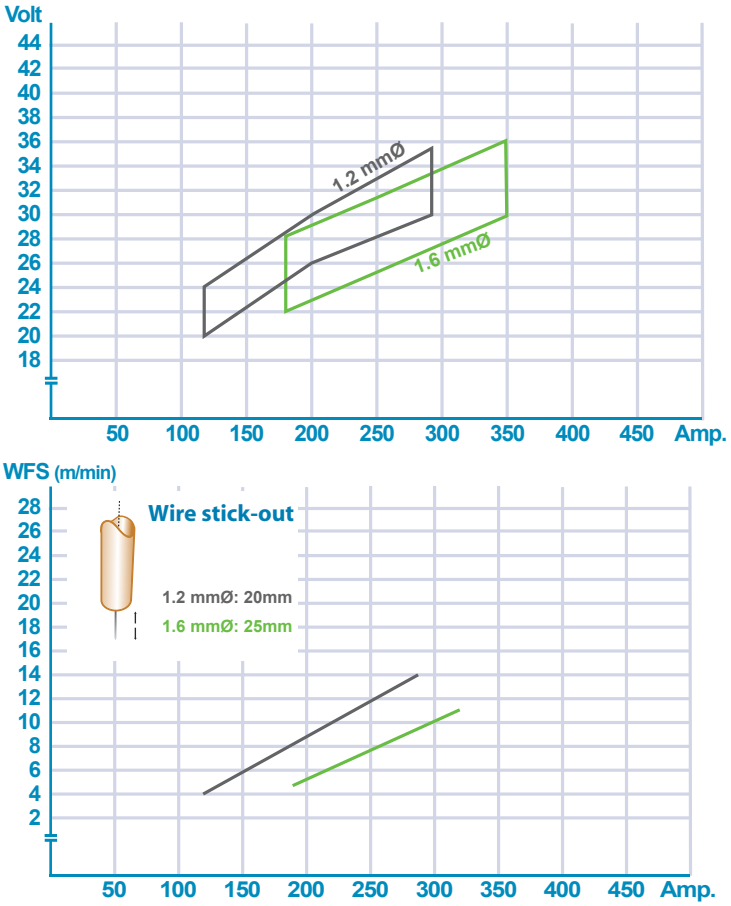
80%Ar - 20%CO_2 / 100%CO_2
EN ISO 17633-A T 23 12 2 L R C/M 3
AWS A5.22 E309LMoT0-1/-4
EN 1.4459

Description and Application

This is a rutile flux cored wire which operates with very stable, spatter free arcs producing bright, smooth weld bead surfaces and self releasing slag.

This wire deposits low carbon weld metal of about 23%Cr-13%Ni-2.3%Mo and is designed for dissimilar welding such as welding stainless steel to mild or low alloy steel. This wire is also suitable for the first layer welding on mild steel or low alloy steel prior to overlaying with **PREMIARC™ DW-316L/LP** or **PREMIARC™ DW-317L**.

Recommended Parameter Range, for flat position*



Typical Chemical Analysis (wt. %)*

	C	Si	Mn	P	S	Ni	Cr	Mo	N	Nb	FS	FN	FNW
	0.02	0.70	1.40	0.018	0.007	12.7	23.2	2.3	-	-	16.8	>18.0	27.0

Typical Mechanical Properties*

	R_e(MPa)	R_m(MPa)	A_5(%)	CV (J)-20°C
	540	700	30	42
Guarantee	min.350	min.550	min.25	

* The above values and parameters are for all weld metal produced using Ar+CO_2 shielding gas

Welding Positions

Approvals

LR	DNV	BV	GL	ABS	R.M.R.S	Others
ss/cmn	309MoL	309MoL	4459S	-	-	TÜV,DB