


NSB-309MoL	FOR WELDING LOW CARBON AUSTENITIC STAINLESS STEELS CONTAINING A NOMINAL 23Cr-12Ni- 3Mo USED FOR DISSIMILAR WELDS BETWEEN STAINLESS AND C-Mn STEELS					DATA SHEET NO. 66					
SPECIFICATION	AWS A5.4		BS EN 1600		JIS Z 3221						
CLASSIFICATION	E309LMo-16		E 23 12 2 L R		D309MoL-16						
PRODUCT DESCRIPTION	<p>A metallurgically advanced rutile based flux formulated with balanced additions of chemically basic, amphoteric and acid minerals, together with small alloy additions to compensate for arc losses.</p> <p>The flux is concentrically extruded onto a fully alloyed core wire and bound by a blend of silicates that assures both coating strength and resistance to subsequent moisture absorption.</p>										
WELDING FEATURES OF THE ELECTRODE	<p>This unique flux formulation ensures excellent arc stability, ease of initial arc strike and re-strike minimal spatter on AC and virtually none on DC+. The resultant weld seams are smooth, evenly rippled and free from undercut while slag detachability is excellent. Metal recovery is some 103% with respect to core wire weight.</p>										
APPLICATIONS AND MATERIALS TO BE WELDED	<p>Applications for the electrode are to be found in the Chemical, Petro-Chemical and Cryogenic Processing and Storage Industries as well as the Food, Brewery and Pharmaceutical Industries.</p> <p>Transition welds between stainless steel and ferritic steel welding clad plate or as a buffer layer on ferritic steel before completing with a more conventional low carbon austenitic stainless steel containing Mo, such as 316 and 316L.</p>										
WELD METAL ANALYSIS COMPOSITION % BY Wt.		C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Fe FN
WELD METAL PROPERTIES (ALL WELD METAL)	PROPERTY		UNITS	MINIMUM	TYPICAL		OTHERS				
WELDING AMPERAGE AC or DC+	Ø (mm)	2.0	2.6	3.2	4.0	5.0					
	MIN	35	65	80	120	160					
	MAX	80	100	125	170	210					
OTHER DATA	Electrodes that have become damp should be re-dried at 150°C for 1 hour.										
RELATED PRODUCTS	Please contact our Technical Department for detail.										