

OK Tigrod 309MoL

A continuous solid corrosion resistant wire 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

Specifications	
Classifications	EN ISO 14343-A : W 23 12 2 L SFA/AWS A5.9 : ER 23 12 2 L SFA/AWS A5.9 : ER309LMo (mod)
Approvals	CE : EN 13479 DNV-GL : 1.6-3.2mm UKCA : EN 13479

Approvals are based on factory location. Please contact ESAB for more information.

Alloy Type	Austenitic (with approx. 8% ferrite) "309LMo", 22 % Cr - 15 % Ni - 3 % Mo - Low C
Shielding Gas	I1 (EN ISO 14175)

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
EN ISO I1			
As Welded	510 MPa	630 MPa	26 %
AWS I1			
As Welded	490 MPa	640 MPa	33 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
EN ISO I1		
As Welded	20 °C	90 J
AWS I1		
As Welded	20 °C	130 J
As Welded	-60 °C	65 J

Typical Weld Metal Analysis %									
C	Mn	Si	S	P	Ni	Cr	Mo	V	Cu
0.01	1.4	0.30	0.002	0.02	14.6	21.1	2.6	0.05	0.1

Typical Weld Metal Analysis %			
N	Nb	Co	FN WRC-92
0.06	0.01	0.05	9

Typical Wire Composition %					
C	Mn	Si	Ni	Cr	Mo
0.01	1.5	0.4	14.6	21.4	2.5