

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 : 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			
Conditional Statement	Yield Strength	Tensile Strength	Elongation
As welded	500 MPa (72.5 ksi)	610 MPa (88.5 ksi)	30 %

Typical Charpy V-Notch Properties	
Testing Temperature	Impact Value
20 °C (68 °F)	130 J (96 ft-lb)
-60 °C (-76 °F)	65 J (48 ft-lb)

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	S	P	Ni	Cr	Mo	V	Cu
0.010	1.5	0.35	0.003	0.018	15.0	21.5	2.6	0.1	0.12

Typical Wire Composition %			
N	Nb	Co	FN WRC-92
0.06	0.01	0.06	9