

Applications

TIG Welding of dissimilar metals such as stainless steels and carbon steels.

Characteristics on Usage

This wire contains a high ferrite level in its austenitic structure thus providing superior heat and corrosion resistance.

ST-309MoL is suitable for the build up on low alloy or mild steel and welding of STS 316, 316L clad steel.

Both bead appearance and weldability are good.

Typical Chemical Composition of Wire (%)

C	Si	Mn	Cr	Ni	Mo
0.02	0.35	1.8	23.2	13.7	2.5

Typical Mechanical Properties of All-Weld Metal

TS MPa(lbs/in ²)	EL (%)
650 (94,200)	32

Typical Welding Conditions (DC-)

Size mm(in)	Currents A	Gas Flow (ℓ /min.)	Shielding gas
1.2 (.045) ~ 2.0 (5/64)	50 ~ 100		
1.2 (.045) ~ 2.0 (5/64)	50 ~ 100		
1.6 (1/16) ~ 3.2 (1/8)	100 ~ 200	25	Ar
2.4 (3/32) ~ 3.2 (1/8)	200 ~ 300		
3.2 (1/8)	300 ~ 400		