

NC-309MoL

For welding of low carbon 22%Cr-12%Ni-Mo stainless steel

AWS	A5.4	E309LMo-16
KS	D 7014	E309MoL-16
JIS	Z3221	ES309LMo-16

Applications

Build up welding of Cr-Mo steel or carbon steel.

Welding of AISI (SUS) 316 or AISI (SUS) 316L to carbon steel.

Clad steel side welding to AISI (SUS) 316 or AISI (SUS) 316L.

Characteristics

NC-309MoL is a lime-titania type electrode for all-position welding, which has good usability and good weldability. Good resistance against dilute sulfuric acid compared with that of NC-309. Weld metals provide excellent corrosion resistibility and heat resistibility in the as-welded condition. As NC-309MoL is of low carbon content, it can be used for welding of extra-low carbon stainless steel which contains Mo and for under laying of mother plates which contain considerably high carbon content.

Notes on usage

- (1) Keep the arc as short as possible and choose the welding current as low as possible.
- (2) Weaving width should be within two and a half times of electrode's diameter.
- (3) When the electrodes have absorbed moisture, dry them at 250~300℃ for 60~90 minutes before use.

Typical chemical composition of weld metal (%)

C	Mn	Si	P	S	Cr	Ni	Mo
0.030	1.20	0.71	0.021	0.006	22.85	13.51	2.35

Typical mechanical properties of weld metal

TS N/mm ² (kgf/mm ²)	EL %
630(64)	38

Size & recommended current range (AC or DC +)

Dia. (mm)		2.6	3.2	4.0	5.0
L (mm)		300	350	350	350
Amp.	F	50-80	70-115	100-150	140-190
	V&OH	45-75	65-110	90-140	-

• Approval : DNV, LR

• Tip Color : Red