



## AUTOTHERME-309LMo

**CODIFICATION:** AWS/SFA 5.9 ER309LMo  
EN ISO : 14343-A G 23 12 2L

### CHARACTERISTICS AND APPLICATIONS:

Autotherme 309LMo is a solid wire for MIG welding, available in bright finish, gives smooth flow, stable arc and spatter free under optimum welding conditions. It gives radiographic quality weld deposit. A highly crack resistant weld deposit which displays good intergranular corrosion resistance and good oxidation and scaling resistance at elevated temperatures. For welding stainless steel of similar composition in wrought or cast form and for overlay application to resist heat and corrosion. Suitable for joining dissimilar steels, such 18-11-Mo steel to mild steel, clad side welding of 18-11-Mo steel, and for buffer layer applications.

### TYPICAL CHEMICAL COMPOSITION OF SOLID WIRE:

Element	C	Mn	Si	P	S	Cr	Ni	Mo
%	0.02	1.50	0.35	0.020	0.010	24.0	13.0	2.5

### TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS	Elongation
(MPa)	(L = 5d) %
580	32.0

**SHIELDING GAS:** Argon

**CURRENT CONDITIONS:** DCEP

**WELDING POSITIONS:** H, F, VU, OH

### PACKING:

**STANDARD SIZE:** Diameter 0.8 mm, 1.2 mm & 1.6 mm

**QUANTITY** 12.5 kgs wire, layer wound in a plastic spool that conforms to DIN 8559 SD-300.