

MIDALLOY CHROMAX E309LMo-16 COATED ELECTRODE

CLASSIFICATION

- AWS 5.4 Class E309LMo-16 / ASME SFA 5.4 Class E309LMo-16 UNS W30934, ASME Sec. IX, F5, A8

DESCRIPTION

- MIDALLOY CHROMAX E309LMo-16 is AC-DC all position Titania Coated Electrode
- Carbon content value is controlled to be less than 0.04%
- Former designation E309MoL-16
- Ferrite content is higher than E309L-16 to help prevent solidification cracking

APPLICATION

- For overlay welding of unalloyed base materials.
- Dissimilar metal welding of carbon and low alloy steels to stainless steel and duplex stainless steels.

TYPICAL CHEMISTRY

C	Cr	Ni	Mo	Mn	Si	P	S	Cu
.03	24.0	13.4	2.5	1.30	.45	.015	.005	.08

TYPICAL MECHANICAL PROPERTIES

TENSILE STRENGTH	90,900 PSI
ELONGATION IN 2"	35%
HEAT TREATMENT	NONE

RECOMMENDED WELDING PARAMETERS

DIAMETER	VOLTAGE	AMPERAGE	
		FLAT	VERTICAL & OVERHEAD
3/32"	24-28	70-85	65-75
1/8"	26-30	85-110	80-90
5/32"	28-32	110-140	100-120
3/16"	28-32	120-160	110-130

STANDARD PACKAGING

- 3/32" 8 lb. can / 48 lb. box
- 1/8" 10 lb. can / 60 lb. box
- 3/16" 10 lb. can / 60 lb. box
- 5/32" 10 lb. can / 60 lb. box

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