

## SK 309 Mo-O

DIN 8555 : MF 9-GF-150  
ASME IIC SFA 5.22 : E309MoT0-3

### DESCRIPTION

1

Self shielded cored wire for the deposit of AISI 309 Mo alloy composition.

### SUITABLE FOR

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Stainless steel cladding on carbon steels, buffer layers on difficult to weld steels, corrosion resistant overlays on rail heads submitted to corrosive action.

### TYPICAL CHEMICAL ANALYSIS (WEIGHT %)

3

	C	Mn	Si	Cr	Ni	Mo	Fe
All Weld	0.05	1.0	0.8	23.50	12.50	2.3	Bal.

### TYPICAL MECHANICAL PROPERTIES

4

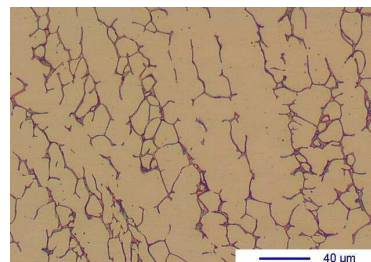
Hardness as welded

170 HB

### GENERAL CHARACTERISTICS

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- Microstructure: Austenite + 15-20 % ferrite
- Machinability: Good
- Oxy-acetylene cutting: Cannot be flame cut
- Deposit thickness: No restriction
- Flux cored



### WELDING PARAMETERS & ECONOMICAL DATA

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Diameter [mm]	Current [A]	Voltage [V]	Stick-Out	Article code	Packaging	Availability
2,4	250-300	26-30	35-40	29465	Spool 15 Kg	On request with minimal quantity
2,4	250-300	26-30	35-40	46517	Spool 25 Kg	On request with minimal quantity

The information about the products contained in the data sheets are based on intensive tests and careful investigations. However we can't assume any form of liability concerning the exactness of it. The information may be changed or updated without previous notice. The user is invited to test the product with regard to his own application and responsibility.