



MIG 24/12M

Old reference: MIG 309LMo

Classification

ISO 14343-A : G 23 12 2 L
 AWS A5.9 : ~ER309LMo

Material N° : 1.4459

Description & Applications

Solid wire electrode with low carbon content for Gas Metal Arc Welding. Used to weld stainless steels with similar composition stainless steels to carbon steels, for buffer layers and for surfacing. Well adapted for welding of dissimilar steels, carbon to stainless steels. Also suitable as buffer layer before hardfacing. High resistance against cracking and corrosion.

Typical Chemical Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	P	S	Fe	FN
0.015	0.55	1.5	21.5	14.5	2.6	0.1	<0.02	<0.01	Rem.	~ 12

All Weld Metal Mechanical Properties

R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
400	600	35	20°C 120

Welding Current & Instructions

Welding mode	Ø wire (mm)	Welding parameters		Shielding Gas
		Pulsed arc (A)	(V)	
MIG =+	0.8	100-150	22-27	Ar + 2%CO2 Ar + 1%O2 18-20 l/min
	1.0	120-200	24-28	
	1.2	140-220	24-28	
	1.6	180-260	24-30	

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