



SELECTARC UP 309LMo

Classification

AWS A5.9 : ~ER 309LMo
ISO 14343-A : S 23 12 2L

Material N° : 1.4455

Characteristics

Wire for submerged arc welding and cladding. Mainly used as first layer followed by UP 316L to get a 316L deposit

Applications

Mainly used to weld Mild Steel / Construction Steel to Stainless Steels 304 or 316L, Overlay on Low alloy steel & Carbon steel.

Typical Wire Composition (%)

C	Si	Mn	Cr	Ni	Mo	P	S	Fe
0.015	0.55	1.50	21.50	14.50	2.60	0.015	0.010	base

All Weld Metal Mechanical Properties (Typical)

Conditions	UTS	YS	% Elg	Impact (KV)	
	R _m (MPa)	R _{p0.2} (MPa)	A ₅	Temp. °C	J
AW	600	400	35	+ 20	120

Welding Current & Instructions

Process	Ø (mm)	Welding Parameters			Flux
		Current (A)	Voltage (V)	Speed cm/mim	
SAW = +	2.4	300 - 350	25 - 28	45 - 55	UP WP 380 UP WP 380M UP Inox L
	3.2	450 - 500	25 - 28	45 - 55	

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