Supercore™ 309MoP

TOP FEATURES

- Made of Austenitic steel sheath and rutile flux system
- Metal recovery is about 90%
- High deposition rates.

CLASSIFICATION

AWS A5.22	E309LMoT1-1/4
EN ISO 17633-A	T 23 12 2 L P C/M 2
EN ISO 17633-B	TS309LMo-F C1/M21 1

CURRENT TYPE

DC+

SHIELDING GASES (ACC. EN ISO 14175)

M21	Mixed gas Ar+ 15-25% CO_2
Flow rate	20-25 l/min

Proprietary gas mixtures may be used but argon should not exceed 85%.

APPROVALS

DNV
+

CHEMICAL COMPOSITION (WEIGHT %), WELD METAL

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	FN
Min.		0.5				22.0	12.0	2.0		15
Max.	0.04	2.0	1.0	0.025	0.030	25.0	14.0	3.0	0.3	25
Typical	0.03	1.3	0.7	0.01	0.02	23	12.8	2.3	0.1	20

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

As welded		Min.	Typical
Tensile strength	(MPa)	550	700
0.2% Proof strength	(MPa)	350	550
Elongation (%)	4d	25	32
	5d	25	30
Reduction of area	(%)		40
Impact ISO-V (J)	+20°C		50
Hardness	(HV)		245

PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.2	SPOOL (S300)	15.0	SC309MOP-12

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:

Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.