

INERTFIL 309LMo

TOP FEATURES

- The weld metal has a delta-ferrite content of ~15% resulting in a high resistance to hot cracking.
- Also used for buffer layers prior to surfacing, where the Mo is a required alloying element.
- Used for dissimilar joints such as carbon and duplex.

TYPICAL APPLICATIONS

- Dissimilar joints
- Cladding

CLASSIFICATION

AWS A5.9 ER309LMo*
EN ISO 14343-A G 23 12 2 L

* Nearest classification

SHIELDING GASES (ACC. EN ISO 14175)

M12 Mixed gas Ar+ 0.5-5% CO₂
M13 Mixed gas Ar+ 0.5-3% O₂

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, WIRE

C	Mn	Si	P	S	Cr	Ni	Mo
0.012	1.44	0.35	0.019	0.002	21.5	14.5	2.6

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) +20°C
Typical values	M13	AW	≥350	≥550	≥30	≥55

* AW = As welded

PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.0	SPOOL (BS300)	15.0	W000283100
1.2	SPOOL (BS300)	15.0	W000283101

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.