

OK Autrod 309MoL GMAW

G 23 12 2 L

Description

A continuous, solid, corrosion-resistant wire of the 309LM type.
OK Autrod 309MoL is used for the overlay welding of unalloyed and low-alloyed steels and for welding dissimilar steels, such as 316L, to unalloyed and low-alloyed steels when Mo is essential.

Welding current

DC(+)

Classifications

EN 12072 G 23 12 2 L

Typical chemical composition, aw (%)

C	Si	Mn	Cr	Ni	Mo
<0.03	<1.0	1.8	23.0	13.3	2.8

Typical mech. properties all weld metal

Yield stress, MPa	400
Tensile strength, MPa	600
Elongation, %	31

Charpy V

Test temps, °C	Impact values, J
+20	110

Approvals

RINA	Restricted availability
UDT	DIN 8556
VdTÜV	

Welding parameters

Diameter, mm	Wire feed, m/min	Welding current, A	Arc voltage, V	Deposition rate kg weld metal/hour
0.8	3.4-11.0	50-140	16-22	0.8-2.6
1.0	2.9-8.4	80-190	16-24	1.0-3.2
1.2	4.9-8.5	180-280	20-28	2.7-4.6
1.6	3.2-5.5	230-350	24-28	3.0-5.2