



LA309LMo

STANDARD

AWS A5.22 E309LMo T1-1 ; E309LMo T1-4

CHARACTERISTICS

Excellent operating properties, good appearance and slight spatter, corrosive resistance

APPLICATION

For build-up welding of special steel, carbon or low alloy steel, base welding of stainless steel seams or materials.

TYPICAL CHEMICAL COMPOSITION (%)

C	Mn	Si	Cr	Ni	Mo	S&P
0.027	1.17	0.71	23.68	14.86	2.49	≤0.03

MECHANICAL PROPERTIES: (CO₂ SHIELDED)

Strength of Extension σ_b (Mpa)	Ductility δ_5 (%)
≥520	≥35
550	41

WELDING PROCEDURE PARAMETERS

Diameter(mm)	Amperage(A)	Voltage(V)
Φ1.2	140-260	24-32
Φ1.6	200-300	27-34

NOTES

1. CO₂ purity ≥99.5% , gas-flow ≥20L/Min.
2. Deposited metal is unmachinable.
3. Pay attention to wind-resistance.
4. Remove the greasy dirt and moisture.