

SUPRANOX RS 309LMo is a rutile MMA electrode depositing a low C – 22/24%Cr – 12/14%Ni-2,5%Mo weld metal with approx. 16% delta-ferrite promoting high resistance to hot cracking.

This electrode has three main applications:

- Buffer layers and claddings on unalloyed and low-alloy steels which are already corrosion resistant in the first layer.
- Dissimilar joints (austenitic steels to ferritic steels) with operating temperatures up to 300°C. In case of higher temperatures, use SUPRANEL 182.
- Hardenable steels.

Excellent weldability with a spatter free arc, self-releasing slag combined with a very smooth bead appearance.

Rutile electrode for welding AISI 309 steels and for undercoats for plating.

Classification		Approvals	Grade
EN	3581-A: E 23 12 2 L R 12	ABS	E309LMo-16
AWS	A5.4: E 309LMo-16	BV	309LMo
		RINA	309Mo

CE

Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Ferrite
0.03	0.9	0.9	≤ 0.02	≤ 0.02	22.7	12.5	2.3	10-25

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)
				20 °C
As Welded	≥ 350	≥ 550	≥ 30	≥ 40

Materials

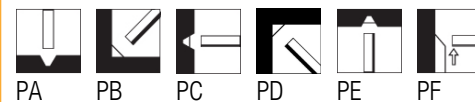
Placari pe oteluri carbon si slab aliate

Storage

Keep dry and avoid condensation.
Re-drying not generally required.
If necessary: 250-300°C for 1 hour, 5 times max.

Current condition and welding position

AC; DC+



Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weightn(kg/1000)	VPMD	
				PC	Code
2.5	300	50-70	19.2	90	W000380839
3.2	350	70-105	37.0	55	W000380158
4.0	350	105-140	55.2	40	W000380159
5.0	450	130-180	87.2	50	W000380840