OK Autrod 309MoL

OK Autrod 309MoL is a stainless steel, over-alloyed wire for submerged arc welding. Suitable for joining of stainless Cr-Ni and Cr-Ni-Mo steels 304, 309 or 316 to ensure corrosion resistance in e.g. the pulp and paper industry. Dissimilar steels when alloying with Mo is essential. OK Autrod 309MoL can be used in combination with OK Flux 10.93.

Specifications	
Classifications	EN ISO 14343-A : S 23 12 2 L SFA/AWS A5.9 : ER 23 12 2 L SFA/AWS A5.9 : ER309LMo (mod)

Alloy Type	Austenitic (with approx. 9% ferrite) 22%Cr - 15%Ni - 3%Mo - Low C

Typical Wire Composition %									
C	**Mn**	**Si**	**S**	**P**	**Ni**	**Cr**	**Mo**	**V**	**Cu**
0.010	1.5	0.35	0.003	0.018	15.0	21.5	2.6	0.1	0.12

Typical Wire Composition %			
N	**Nb**	**Co**	**FN WRC-92**
0.06	0.01	0.06	9