

AK E309LMo-17

Description: 309LMo-17 is a stainless steel electrode depositing low carbon 22Cr - 12Ni - 2.0Mo weld metal. It works well with transformer and good re-striking characteristic. Better welder appeal including, easy slag detachability characteristics. On horizontal fillet welds, produce more of spray arc and a finer rippled weld bead and the bead shape is typically flat to concave. It is ideal for welding stainless steel of similar composition in wrought or cast form and for overlay application to resist heat and corrosion. Suitable for joining dissimilar steels, such 18-11-Mo steel to mild steel, clad side welding of 18-11-Mo steel, and for buffer layer applications.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	Mo	Cr	Cu
Requirement	0.04	1.0	0.5-2.5	0.03	0.04	12.0-14.0	2.0-3.0	22.0-25.0	0.75
Actual Result	0.031	0.62	1.03	0.010	0.025	12.43	2.26	23.35	0.05

Typical Mechanical Properties:

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	≥ 520		≥30	
Actual Result	600		35	