

AK E309LMo-16

Description: A super-low carbon Cr23Ni13Mo2 stainless steel electrode, the carbon content of its deposit metal is $\leq 0.04\%$. The proper Mo element improves corrosion and crack resistance with excellent operation properties and pores k resistance.

Application: Used to weld similar composition super low carbon stainless steels and dissimilar steel structures.

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	0.019	0.65	0.82	0.003	0.018	12.80	2.63	23.40	0.30

Typical Mechanical Properties:

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	≥ 510		≥ 25	
Actual Result	550		41	

Recommended welding parameters:

Diameter/mm		2.5	3.2	4.0
Welding current /A	F/H	60-80	80-120	100-150
	V/ OH	40-70	60-100	80-130