

AK E309Mo-16

Description: AK-E309Mo-16 is a Cr23Ni13Mo2 stainless steel electrode with rutile coating. AC and DC dual-use, can perform all-position welding. The electrode has good welding process performance. Because the weld metal contains molybdenum, it has better corrosion resistance, crack resistance and oxidation resistance than A302.

Application: It is suitable for welding the same type of stainless steel vessels that are resistant to sulfuric acid medium (sulfur ammonia) corrosion, and can also be used for welding stainless steel linings, clad steel plates, and dissimilar steels.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	Mo	Cr	Cu
Requirement	0.12	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	0.05	0.67	0.96	0.01	0.025	12.33	2.43	23.77	0.20

Typical Mechanical Properties:

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	≥ 550		≥25	
Actual Result	595		36	

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