

MIG-MAG Wires Stainless and Heat resistant steels

Inertfil 309LMo is a stainless steel solid wire containing a 25%Cr 12%Ni low C and high Mo. Suitable for welding AISI 309 austenitic stainless steel and similar steels. Inertfil 309LMo is also used to weld dissimilar steels or for buffer layers on 316L.

Classification	
AWS	A5.9: ER 309L Mo (approx)
EN	12072: G 23 12 2L

Approvals	Grades
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Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Cu	N	Ferrite
0.03	1.60	0.45	≤ 0.030	≤ 0.020	22	15	2.70	-	-	-	10-20

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) 20°C	Hardness
As Welded	≥ 350	≥ 550	≥ 30	≥ 47	-

Gas test: Acc. To EN 439: M13(Cargal1)

Shielding Gas: Acc. To EN 439: M13(Cargal1)

Materials

Cladding of carbon steel and low alloy steel

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+					
					
PA	PB	PC	PF	PE	PF2

Packaging data: BS300 Kg. 15

Diameters	0,8	1,0	1,2			