

# INERTROD 309LMo

## TIG Rods Stainless and Heat resistant steels

Inertrod 309LMo is a stainless TIG rod with 25Cr 12Ni low C and high Mo. Suitable for welding austenitic stainless steels such as AISI 309. Inertrod 309LMo is also used for welding dissimilar steels and for buffer layers.

Classification	
AWS	A5.9: ER 309L Mo
EN	12070: W 23 12 2 L

Approvals	Grades

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

Gas test: Acc. To EN 439: I1(Arcal1)

**Shielding Gas:** Acc. To EN 439: I1(Arcal1)

### Materials

Cladding of carbon steel and low alloy steel

### Storage

Keep dry and avoid condensation

### Current condition and welding position

DC-



**Packaging data:** Tube 5 kg

Diameters (L: 1000 mm)	1,6	2,0	2,4			
------------------------	-----	-----	-----	--	--	--

Further forms of delivery on request.