

MIG/MAG Cored Wires Stainless and Heat resistant steels

FLUXINOX 309MoL-PF is an alloyed rutile flux cored wire mainly used for cladding. The highest operating temperature for dissimilar joints is 300°C and the weld metal is non-scaling up to 850 °C. Preheating and interpass temperatures should be calculated according to the base metal used. FLUXINOX 309MoL-PF exhibits outstanding, almost spatter-free, welding properties. It produces finely rippled flat and smooth welds, free of undercut with very easy slag removal. Due to its fast-freezing slag, FLUXINOX 309MoL-PF is used for welding in the horizontal (PD), overhead (PE) and vertical-up (PF) positions.

Classification	
EN ISO	17633-A: T 23 12 2 L P C 1
EN ISO	17633-A: T 23 12 2 L P M 1
EN ISO	17633-B: TS309LMo-FB1
EN ISO	A5.22: E309LMoT1-1
AWS	A5.22: E309LMoT1-4

Chemical analysis (Typical values in %)

C	Mn	Si	Cr	Ni	Mo	Ferrite
≤ 0.04	1.5	0.7	24	13	2.5	12-20

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)
				20 °C
As Welded	≥ 350	≥ 550	≥ 28	≥ 40

Gas test: 82% Ar+18% CO2

Shielding Gas - EN ISO 14175 : C1, M21

Materials

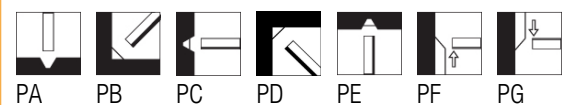
Ferrite-Austenite heterogeneous joints, Cladding

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+



Packaging data

Packaging Type	BS300	S200
Diam(mm) / weight(kg)	15	5
1.0	●	
1.2	●	●