

INERTROD 309LMo is a W 23 12 2 L/ER 309L Mo (similar) type solid TIG welding rod depositing a low C-22Cr 12Ni 2.5Mo weld metal. Suitable for use mainly with Ar shielding gas.

INERTROD 309LMo is used for the welding of stainless steels to mild and medium tensile steels. Used for intermediate layers on structural steel prior to depositing 316L grade stainless steel cladding. Also used for buffer layers prior to surfacing, when Mo is a required alloying element.

The weld metal has a delta-ferrite content of ~15% resulting in good resistance to hot cracking.

### Classification

EN ISO	14343-A: W 23 12 2 L
AWS	A5.9: ~ER 309LMo

### Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Ferrite
0.020	1.6	0.45	≤ 0.025	≤ 0.020	22	15	2.7	10-20

### 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	≥ 30	≥ 55

Gas test: 100% Ar

**Shielding Gas** - EN ISO 14175 : I1

### Materials

Ferrite-Austenite heterogeneous joints ("Black-White"),

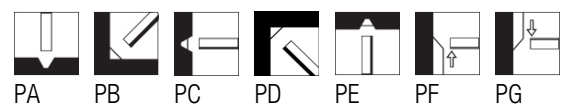
Corrosion resistance surfacing

### Storage

Keep dry and avoid condensation

### Current condition and welding position

DC-



### Packaging data

Diam. (mm)	Packaging Type	Weight (kg)	Code
1.6	TUB	5	●
2.0	TUB	5	●
2.4	TUB	5	●