

EI 309MOL

Coated Electrode for Stainless Steels -

Standards

AWS/ASME SFA - 5.4	E309LMo-16
EN ISO 3581 - A	E 23 12 2 L R 12
TS EN ISO 3581 - A	E 23 12 2 L R 12
DIN M. No.	1.4459

Approvals & Certificates

GOST	TUV	TSE
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Properties and Applications

Rutile type stainless electrode for joining dissimilar steels (austenitic steels to ferritic steels) and for austenitic claddings. Weld metal consists of austenite with approx. 15% delta-ferrite. Claddings on unalloyed and low-alloy steels are already corrosion resistant in the first layer, due to Mo (molybdenum) content. Higher operating temperature for joints between dissimilar steels is 300°C. In the cases of higher temperatures, use ENI 422 electrodes. Fine metal droplet transfer, good fusion of joint faces, finely ripped bead surface, easy slag removal, easy arc striking and restriking.

Typical Chemical Values of Weld Metal

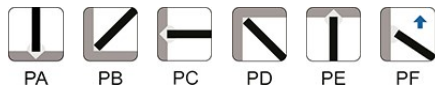
Type of Analysis	C	Si	Mn	CR	Ni	Mo
Weld Deposit	0.02	0.90	0.95	23.50	12.50	2.50

Typical Mechanical Values of Weld Metal

Test Condition	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A5 (%)	Charpy V-Notch Properties (J)
As welded	600	720	30	20°C → 50

Application Information

Welding Positions



Polarity:



Welding Parameters & Efficiency

Diameter x Length (mm)	Current (A)
2.00x300	40-60
2.50x300	50-80
3.25x300	80-120
3.25x350	80-120
4.00x350	100-165

Packaging Information

Product Code	Diameter x Length (mm)	Quantity per Box	Box Gross Weight (kg)	Boxes per Outer Box	Outer Box Gross Weight (kg)	Packaging Type
13010DDEM2	2.00x300	205 pcs	2.62	3	8.00	Plastic Box
13010DJEM2	2.00x300	143 pcs	1.79	9	16.30	VAC Box
13010G9EM1	2.50x300	15 pcs	0.00	30	0.00	Blister
13010GDEM2	2.50x300	128 pcs	2.62	3	8.00	Plastic Box
13010GJEM2	2.50x300	89 pcs	1.79	9	16.30	VAC Box
13010M9EM1	3.25x300	10 pcs	0.00	30	0.00	Blister
13010MDEM2	3.25x300	77 pcs	2.62	3	8.00	Plastic Box
13010MJEM2	3.25x300	54 pcs	1.79	9	16.30	VAC Box

13010N9EM1	3.25x300	15 pcs	0.00	30	0.00	Blister
13010NDEM2	3.25x350	66 pcs	2.64	3	8.10	Plastic Box
13010NJEM2	3.25x350	53 pcs	2.04	9	18.60	VAC Box
13010QDEM2	4.00x350	44 pcs	2.60	3	8.10	VAC Box
13010QJEM2	4.00x350	35 pcs	2.04	9	18.60	VAC Box

Storage & Re-Drying Information

It can be dried maximum 5 times.
It should be stored in a dry room (relative humidity < 50%, room temperature > 20°C) on wooden pallets.
It has to be dried at 350°C for 2 hours.