CWR-309LMo Welding Wire and Rod

CWR-309LMo is typically used to weld type 316 clad steels on the first pass in cladding steel as well as to weld dissimilar metals such as molybdenum-bearing stainless steels to carbon or low alloy steels.

CONFORMANCES

AWS A5.9/A5.9M	:	ER 309LMo
ASME SFA-A5.9	:	ER 309LMo
ISO 14343-B	:	SS309LMo

AWS CHEMICAL COMPOSITION *(TYPICAL)*

%C	%Cr	%Ni	%Mo	%Mn
0.03 max	23.0 – 25.0	12.0 – 14.0	2.0 – 3.0	1.0 – 2.5

%Si	%P	%S	%Cu	Total Others
0.30 – 0.65	0.03 max	0.03 max	0.75 max	0.50 max

TYPICAL WELD METAL MECHANICAL PROPERTIES

Yield Strength	:	56,000 psi
Tensile Strength	:	85,000 psi
Elongation	:	35 %

TYPICAL WELDING PARAMETERS

Process	Diameter		Voltage	Amperage	Gas/Flux
TIG (GTAW)	1/16”	1.6 mm	14 – 17	90 – 130	100% Ar
	3/32”	2.4 mm	15 – 20	120 – 175	100% Ar
MIG (GMAW)	.035”	0.9 mm	29 – 33	160 – 190	98%Ar – 2%O_2
	.045”	1.1 mm	29 – 33	180 – 220	98%Ar – 2%O_2
Sub Arc (SAW)	.093”	2.4 mm	28 – 33	250 – 450	
	.125”	3.2 mm	29 – 34	300 – 500	

*All parameters are suggested as basic guidelines only and will vary depending on joint design, number of passes and other factors.

IMPORTANT: SPECIAL VENTILATION AND/OR EXHAUST REQUIRED
BEFORE USE, READ AND UNDERSTAND THE SAFETY DATA SHEET (SDS) FOR THIS PRODUCT AND SPECIFIC INFORMATION PRINTED ON THE PRODUCT CONTAINER.