

# S-309MoL.16

TYPE : Rutile

AWS A5.4 / ASME SFA5.4 E309LMo-16  
JIS Z3221 ES309LMo-16  
EN 1600 - E 23 12 2 L R

## Applications

Welding of extra-low carbon 22%Cr-12%Ni-2.5%Mo stainless steel.

## Characteristics on Usage

- S-309MoL.16 is a lime-titania type electrode.
- Corrosion, heat and crack resistibility of the weld metal are superior to those of S-309.16N.
- Suitable for repair welding in dissimilar joint and steels which are difficult to weld.
- The slag removability and welded metal appearance are good.

## Notes on Usage

- ① Dry the electrodes at 350°C(662°F) for 60 minutes before use.
- ② Use currents as low as possible to avoid excessive dilution.
- ③ Keep the arc as short as possible.

## Welding Position



1G 2F 3G 4G  
(PA) (PB) (PF) (PE)

## Current

AC or DC +

## Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Ni	Mo
0.02	0.72	1.41	0.027	0.013	23.3	12.7	2.4

## Typical Mechanical Properties of All-Weld Metal

TS MPa(lbs/in <sup>2</sup> )	EL (%)
690 (100,000)	33.8

## Approval

DNV, TÜV, CE, DB

## I Packing

Packet 2.5 kg (5.5 lbs)  
Carton 2.5 kg (5.5 lbs) × 4 : 10kg(22 lbs)

## Sizes Available and Recommended Currents (Amp.)

Size mm (in)	2.0 (5/64)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)
Length mm(in)	300 (12)	300 (12)	350 (14)	350 (14)	350 (14)
F	25~55	50~85	70~115	95~150	135~180
V-up, OH	20~50	45~80	65~110	85~135	-