



WB309LMo-M MIG WELDING WIRE

Classifications	AWS A5.9: ER309LMo BS EN ISO 14343-A: G 23 12 2 L										
Product Description	309LMo stainless steel, solid MIG wire.										
Applications	WB309LM is used mainly for welding stainless steels and wrought and cast alloys to carbon steels such as 304 clad steels. This is known as a transition/dissimilar weld used largely for pressure vessel fabrications.										
Wire Composition (Wt. %)		C	Mn	Si	S	P	Cr	Ni	Mo	Cu	
min.		-	1.0	0.30	-	-	21.0	11.0	2.0	-	
max.		0.03	2.5	0.65	0.03	0.03	25.0	15.5	3.5	0.50	
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		510 min.						
	Yield Stress/0.2% Proof Stress		N/mm ²		320 min.						
	Elongation on 5D		%		25 min.						
	Impact Energy CV @		Joules		-						
	As welded										

Wire Dia. (mm)		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
Current Range (Amps)	min.	-	80	120	160	180	-	-
	max.	-	180	240	260	300	-	-
Volt Range (Volts)	min.	-	17	17	18	20	-	-
	max.	-	20	22	26	29	-	-
Packaging Information								
Kg Per Reel		-	0.7/15/ 250	15/250	15/250	15/250	-	-
Storage	Storage It is recommended that the WB range of wires are stored in a dry heated store at a minimum temperature of 18°C, and a maximum relative humidity of 60%.							
Gases	Gas Argon + 2%O ₂ or Argon + 2-3%CO ₂							
	Flow Rate 15-20 L/min							

Current Conditions DC+ and Welding Positions

