

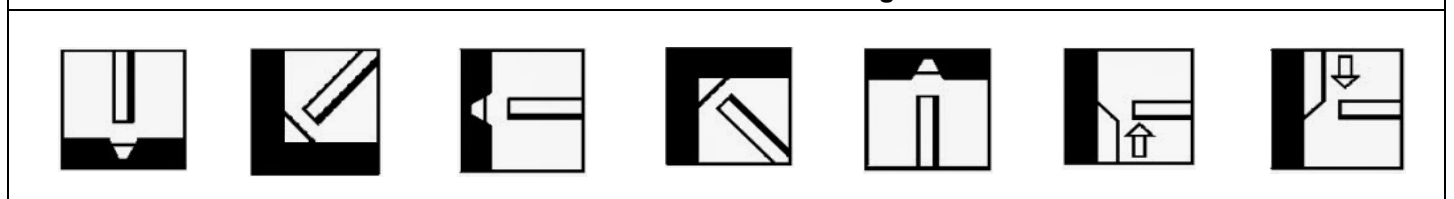


WB309LMoT TIG WELDING WIRE

Classifications	AWS A5.9: ER309LMo BS EN ISO 14343-A: W 23 12 3 L									
Product Description	309LMo stainless steel, solid TIG wire.									
Applications	WB309LMoT 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	-	-	23.0	12.0	2.0	-	
max.	0.03	2.5	0.65	0.03	0.03	25.0	14.0	3.0	0.50	
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength					N/mm ²	789			
	Yield Stress/0.2% Proof Stress					N/mm ²	568			
	Elongation on 5D					%	32			
	Impact Energy CV @ +20°C					Joules	67			
	As welded									

Wire Dia. (mm)		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
Current Range (Amps)	min.	-	-	-	-	80	80	80
	max.	-	-	-	-	120	120	120
Volt Range (Volts)	min.	-	-	-	-	-	-	-
	max.	-	-	-	-	-	-	-
Packaging Information								
Kg Per Tube		-	-	-	-	5	5	5
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 Pure Argon Flow Rate 10-14 L/min							

Current Conditions DC- and Welding Positions



Approvals: CE