



PRODUCT DATA SHEET

STAINLESS STEEL ELECTRODES

WCD 6117

Staincord 309Mo-16



SUMMARY

- > All Positional, Rutile Type Stainless Steel Electrode
- > Moisture Resistant Flux Coating/"Extra" Low Carbon Deposit
- > Suitable for the Dissimilar Welding of Stainless Steel to Mild/Low Alloy Steels.

IDENTIFICATION

Coating - Grey **Tip** - Black **Imprint** - WIA 309MO-16

CLASSIFICATION

- > AS/NZS 4854-B - ES309LMo-16
- > AWS A5.4: E309MoL-16

DESCRIPTION AND APPLICATION

Staincord 309Mo-16 is an extra low carbon, rutile type electrode exhibiting superior all positional (except vertical down performance with an improved moisture resistant coating for weld metal of high radiographic integrity. The smooth arc action of Staincord 309Mo-16, together with low spatter and excellent slag control/detachability, promotes exceptional weld appearance and profile.

Staincord 309Mo-16 is a Molybdenum bearing, highly alloyed 23Cr/12Ni/2.5Mo stainless steel electrode for welding matching 309 and 309Mo base metals. Major applications of Staincord 309 Mo-16 also involve the welding of a wide range of 300 and 400 series stainless steels to mild/low alloy steels. 309M is also suitable for general welding applications with alloyed and non-alloyed dissimilar ferrous metal combinations.

OPERATIONAL DATA

ELECTRODE SIZE (MM)	ELECTRODE LENGTH (MM)	WELDING CURRENT RANGE *(A)	ARC VOLTAGE RANGE **(V)
2.5	300	50 - 75	22
3.2	350	75 - 110	26

*Recommended for DC +/- or AC (minimum 70 OCV) operation.
 **Voltage is determined by arc current and electrode arc length.
 Arc voltage shown is typical and is only to be used as a guide.

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

C	Cr	Ni	Mo	Mn	Si	P	S	Cu
0.03	23.51	13.12	2.39	0.79	0.64	0.028	0.027	0.16

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

Yield Stress	400 MPa
Tensile Strength	670 MPa
Elongation	38%

PACKAGING DATA

ELECTRODE SIZE (MM)	PACKAGING (KG)		APPROX. NO. OF RODS PER KG	PART NO.
	PACKET	CARTON		
2.5	2.5	12.5	56	SC309M025
3.2	2.5	12.5	30	SC309M032

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