



# Cromarod 309MoLP

SMAW - (Stick) - MMA  
Stainless Steel

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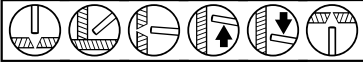
### Description:

Cromarod 309MoLP is a fully-positional rutile flux coated electrode specially designed for applications requiring optimum positional operability. The high alloy content and ferrite level enables the weld metal to tolerate dilution from dissimilar and difficult-to-weld materials without hot cracking. The relatively thin coating and fast-freezing slag makes Cromarod 309MoLP particularly suitable for welding dissimilar joints of differing thicknesses e.g. 4 mm stainless to 7 mm medium carbon steel.

### Applications:

- Dissimilar joints between stainless and mild, low or medium carbon steels.
- Joining of medium carbon hardenable steels, e.g. armour plate.

### Welding positions:



### Coating type:

Rutile

### Welding current:

DC +, AC OCV > 50V

### Ferrite content:

FN 20 (WRC-92)

### Redrying temperature:

350 °C, 2h

### Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min		0,5	0,5			22,0	12,0
Typical	0,02	0,7	1,0	0,02	0,02	23,2	13,0
Max	0,040	1,0	2,0	0,030	0,025	25,0	14,0

	Mo	Cu	V	Nb
Min	2,0			
Typical	2,5			
Max	3,0	0,5	0,1	0.1

### Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Rp0.2%:	≥ 350 MPa	550 MPa
Tensile Strength, Rm:	≥ 560 MPa	720 MPa
Elongation, A5	≥ 30 %	33%
Impact energy, CV:		-20 °C • 50 J

### Classification:

EN 1600	E 23 12 2 L R 11
AWS A5.4	E 309MoL-17
ISO 3581-A	E 23 12 2 L R 11

### Approvals:

CE

### Note

Core wire:  
P ≤ 0.020%  
S ≤ 0.015%  
N ≤ 0.080%

### Produkt data:

Diam.mm	Length mm	Product code	Current A	Voltage V	Kg weld metal/ kg electrodes	No. of electrodes/ kg weld metal	Kg weld metal/ hour arc time	Burn-off time/ electrode (sec.)
2,5	300	74332500	35-80	23	0,66	98	0,9	45
3,2	350	74333200	40-100	23	0,73	41	1,4	53