



S.S. Flux Cored Wire - Gas Shield Type



Code & Specification

ASME SFA/AWS A5.22 E309LMoT1-1

Description

BLUME[®] E309LMo is a rutile type gas shield flux cored arc welding wire, austenite structure weld metal. This weld metal contains Mo element to get good high temperature strength, good crack and inter-granular corrosion resistance. It has a low spatter loss and easy slag removal.

Shielding Gas

Carbon Dioxide (CO₂) / Mixed Gas

Applications

BLUME[®] E309LMo dissimilar metal welding of SUS316L to carbon steels or low alloy steels. Cladding of SUS316L, 316L to carbon steels and low alloy steels.

Mechanical Properties

Tensile Strength MPa	559
Elongation %	38

Undiluted Weld Metal Analysis (wt%)

C	Mn	Si	Ni	Cr
≤ 0.03	0.50 - 2.50	≤ 1.00	12.0 - 16.0	22.0 - 25.0
Mo				
2.00 - 3.00				

Suggested Welding Parameters (DC+)

Diameter	Flat		Vertical		Overhead	
	Volts	Amps	Volts	Amps	Volts	Amps
1.2mm (.045")		150 - 250		100 - 140		100 - 140
1.6mm (1/16")		200 - 300				

Packaging

15 kgs (33 lbs) [Net Weight] Plastic spools with OD = 270mm (11")

Approvals

