

CORODUR[®] TS 309 L Mo

CLASSIFICATION:

T 23 12 2 L R M 3 (C3)
T 309 L Mo T0 1- 4
1.4459

GENERAL CHARACTERISTICS:

Flux cored wire with an alloyed core, suitable for joining difficult-to-weld steels and for corrosion-proof claddings. An austenitic weld metal (Cr Ni Mo 18/ 10/ 2) is obtained already in the first layer. The alloy is also suitable for welding buffer layers on plated metal sheets and for joining austenitic to ferritic steels which are subject to service temperatures of up to 350° C.

Due to its high alloy level CORODUR TS 309 L Mo produces crack-proof welds.

The addition of molybdenum ensures higher corrosion resistance and higher tensile-strength at elevated temperatures, as compared to the moly-free material 1.4829.

The weld metal is heat resistant and non-scaling up to 1050° C

APPLICATION:

Dissimilar joints of :

1.4583 with H I / H II. 17 Mn 4. StE 355.

1.4583 with P235GH / P256GH, P295GH, P355N

Buffering before cladding

Joining of stainless steels to mild or low-alloyed steels at high dilution levels

TYPICAL ALL WELD METAL ANALYSIS (%):

C	Si	Mn	Cr	Ni	Mo
0,03	0,8	1,4	23,0	13,5	2,8

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Tensile strength R _m N/mm ²	Yield strength R _{p0,2} N/mm ²	Elongation A ₅ %	Impact strength J
760	590	32	+ 20 C°; 50

FORMS OF DELIVERY:

Diameter / mm	Sales units	Shielding gas
1,2	BS 300	Argon + Co ₂
1,6	BS 300	Argon + Co ₂