

DIFFUSALOY 309 Mo

A “Lo Temp” all – positional austenitic stainless steel electrode for the welding of stainless steels of AISI types 309, 316 clad steels and 310. It is also used for dissimilar and unknown stainless steels and for joining these to steels. Also for cushioning of medium and high carbon steels, tool and die steels. Recommended for overlays on carbon steels of corrosion resistance and high temperature service upto 1100⁰C.

Applications:

Designed for elevated temperature applications requiring a high oxidation resistance and high strength at temperature upto 1100⁰C. Ideal for welding furnace parts, heat exchangers, heat treatment boxes, kiln cooler plates and for clad steels.

Procedure :

Pre heat at 150⁰C is recommended before use.
 Clean weld area. Clamp and tack weld at short intervals.
 Use electrode on AC/DC + at the lowest amps.
 Maintain very short arc and chip slag between passes. Avoid weaving.

<u>Technical Data</u>	:	DIFFUSALOY 309 Mo			
Size (mm)	:	2.5	3.15	4.00	5.00
Recommended Welding Current (Amps)	:	40 – 70	70 – 100	90 – 135	130 - 165
Tensile Strength	:	58 kgf / mm ²			
Elongation (l = 4d)	:	26% (Min.)			

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