

TASETO Welding Materials

Stainless Steel Electrodes

For Flux Cored Arc Welding

GFW309MoL

Applicable Specification

JIS Z 3323 TS309LMo-FB0
AWS A5.22 E309LMoT0-1/4

● Applications and Characteristics

TASETO GFW309MoL has the same uses as GFW309Mo. As the carbon content is decreased to 0.04% or less, it is suitable for welding first layer of Type 316L stainless steel overlay or clad steel.

● Notes on Usage

* Please refer "Guideline for Welding Stainless Steel with GFW Wires".

● Chemical Composition of All Weld Metal (%)

	C	Si	Mn	P	S	Ni	Cr	Mo	Cu
Typical	0.021	0.64	1.15	0.020	0.003	12.69	23.08	2.31	0.02

● Ferrite Content of All Weld Metal

* Typical Ferrite Content: 18.3% (Schaeffler's Diagram)
>18FN (DeLong's Diagram)
25% (Ferrite Scope)

● Mechanical Properties of All Weld Metal

	0.2% Proof Stress (MPa)	Tensile Strength (MPa)	5D Elongation (%)
Typical	515	686	30.0

● Sizes Available, Shielding Gas

Size (mm)	Shielding Gas
1.2	CO ₂ or Ar+20%CO ₂ , 20L/min
1.6	CO ₂ or Ar+20%CO ₂ , 20L/min