

TASETO Welding Materials

Stainless Steel Electrodes

For Shielded Metal Arc Welding

RNY309MoL

● Applicable Specification

JIS Z 3221 ES309LMo-16

AWS A5.4 E309LMo-16

● Identification Color

End Face: Silver

Side Face: Neutral Green

● Applications and Characteristics

TASETO RNY309MoL has the same characteristics as RNY309Mo except low carbon content in all weld metal less than 0.04%. It is particularly suitable for applying the first layer of overlay welding of Type 316L.

RNY309MoL is a lime-titania type electrode suitable for positional welding.

● Notes on Usage

* Dry the electrode at 150°C to 200°C for 60 minutes before use.

* Remove oil and dust from the surface to be welded.

● Chemical Composition of All Weld Metal (%)

	C	Si	Mn	P	S	Ni	Cr	Mo	Cu
Typical	0.036	0.49	1.38	0.019	0.007	13.21	23.92	2.51	0.13

● Mechanical Properties of All Weld Metal

	Tensile Strength (MPa)	5D Elongation (%)	Absorbed Energy at 20°C (J)
Typical	677	33.6	79

● Other Properties of All Weld Metal

* Typical Ferrite Content : 16.4% (Schaeffler's Diagram)

● Sizes Available, Recommended Welding Currents (AC or DCEP)

Size (mm)	Length (mm)	Welding Current (A)	
		Flat	Vertical, Overhead
2.6	300	50~90	45~80
3.2	350	80~120	65~110
4.0	350	110~150	85~135
5.0	350	150~200	—