

# TASETO Welding Materials

Stainless Steel Electrodes

For Flux Cored Arc Welding

## GF309Mo

Applicable Specification

JIS Z 3323 TS309Mo-FB0

AWS A5.22 E309LMoT0-1/4

### ● Applications and Characteristics

TASETO GF309Mo has the same uses as GF309. As Mo is added about 2% in weld metal, GF309Mo is suitable for welding first layer of Type 316 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	0.034	0.60	1.19	0.020	0.003	12.82	22.87	2.37	0.02

### ● Ferrite Content of All Weld Metal

\* Typical Ferrite Content: 15.5% (Schaeffler's Diagram)  
>18FN (DeLong's Diagram)  
24% (Ferrite Scope)

### ● Mechanical Properties of All Weld Metal

	0.2% Proof Stress (MPa)	Tensile Strength (MPa)	5D Elongation (%)
Typical	500	683	32.0

### ● Sizes Available, Shielding Gas

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