

TASETO Welding Materials

Bare Stainless Steel Rods

For Gas Tungsten Arc Welding

TG309Mo

● Applicable Specification

JIS Z 3321 YS309Mo
AWS A5.9 ER309Mo

● Identification Color

End Face : Silver

● Applications and Characteristics

TASETO TG309Mo is the welding material with the chemical composition of 25%Cr-12%Ni-2%Mo. The addition of Mo provides weld metal excellent crack resistibility. TG309Mo is suitable for the first layer of Type 316 stainless steel overlay.

● Chemical Composition of Wire (%)

	C	Si	Mn	P	S	Ni	Cr	Mo	Cu
Typical	0.052	0.41	1.78	0.010	0.010	13.71	24.05	2.34	0.04

● Mechanical Properties of All Weld Metal

	0.2% Proof Stress (MPa)	Tensile Strength (MPa)	4D Elongation (%)
Typical	489	680	34.6

● Sizes Available and Recommended Welding Currents (DCEN)

Rod Diameter (mm)	0.8	0.9	1.0	1.2	1.6	2.0	2.4	2.6	3.2	4.0	5.0
Rod Length (mm)	1000										
Welding Current (A)	50~80		50~120			100~200			150~250		220~280

*Rod Diameter 0.8, 0.9 mm : Made to order products