

TASETO Welding Materials

Bare Stainless Steel Rods

For Gas Tungsten Arc Welding

TG309MoL

● Applicable Specification

JIS Z 3321 YS309LMo
AWS A5.9 ER309LMo

● Identification Color

End Face : Silver
Side Face : Orange

● Applications and Characteristics

TASETO TG309MoL has the same use as TG309Mo. As the carbon content is decreased, it is suitable for welding of the first layer of Type 316L stainless steel overlay welding or clad steel where corrosion resistibility is required.

● Chemical Composition of Wire (%)

	C	Si	Mn	P	S	Ni	Cr	Mo	Cu
Typical	0.014	0.41	1.97	0.009	0.008	13.82	24.03	2.46	0.04

● Mechanical Properties of All Weld Metal

	0.2% Proof Stress (MPa)	Tensile Strength (MPa)	4D Elongation (%)
Typical	461	659	36.3

● 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