



# Cromarod 309MoL-S

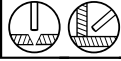
SMAW - (Stick) - MMA  
Stainless Steel

Date: 2007-10-19  
Revision: 16

## Description:

Cromarod 309MoL-S is a high efficiency electrode with a rutile, metal powder coating on an unalloyed core wire. This cost-effective design permits high welding currents to be used without risk of overheating and the 160% recovery gives extended run lengths with increased productivity. The electrode is intended for dissimilar joints between stainless and mild or low alloy steels, as well as for buffer layers. A forceful and stable arc enables welding direct on to thick coated shop primer without risk of porosity. Cromarod 309MoL-S is extremely easy to handle, with self-detaching slag and smooth weld bead appearance.

## Welding positions:



## Coating type:

Rutile, high recovery 160%

## Welding current:

DC +, AC 0CV > 39V

## Ferrite content:

FN 15 (WRC-92)

## Redrying temperature:

350 °C, 2h

## Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min			0,5			21,0	11,0
Typical	0,05	0,9	0,7	0,02	0,02	23,3	12,2
Max	0,12	1,2	2,0	0,030	0,025	25,0	14,0

	Mo	Cu	V	Nb
Min	2,0			
Typical	2,3			
Max	3,0	0,5	0,1	0,1

## Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Rp0.2%:	≥ 350 MPa	530 MPa
Tensile Strength, Rm:	≥ 560 MPa	700 MPa
Elongation, A5	≥ 25%	28%

## Product data

Diam.mm	Length mm	Product code	Current A	Voltage V	Kg weld metal/kg electrodes	No. of electrodes/kg weld metal	Kg weld metal/hour arc time	Burn-off time/electrode (sec.)
3,2	450	74373200	110-170	29	0,60	23	1,8	79
4,0	450	74374000	150-230	31	0,60	16	2,8	80

## Classification:

EN 1600 ~E 23 12 2 L R 73  
AWS A5.4 ~E 309Mo-26  
ISO 3581-A ~E 23 12 2 L R 73

## Approvals:

DNV  
CE  
GL

## Note

AWS deviation in Si.  
EN and ISO deviation in C

Core wire:  
P ≤ 0.015%  
S ≤ 0.015%  
N ≤ 0.080%