

# Gas Metal Arc Welding

JIS Z3321 Y309Mo  
 AWS A5.9 ER309Mo  
 DIN 8556-SG 1.4459

## MS M-309Mo Solid Wires for Stainless Steel

**Applications** Suitable for welding of stainless steel to carbon steel and root runs in cladding. Addition 2.03.0%Mo to increase its pitting corrosion resistance in halide-containing environments.

Brand Name		MS M-309Mo							
Representative of diameter (mm)	0.8	0.9	1.0	1.2	1.6	-	-	-	-
Chemical composition of wire (%)	C	Si	Mn	P	S	Ni	Cr	Mo	-
	≤ 0.12	≤ 0.65	1.0-2.5	≤ 0.03	≤ 0.03	12.0 - 14.0	23.0-25.0	2.0-3.0	-
Mechanical property of deposited metal									
Tensile strength	≥ 550 N/mm <sup>2</sup>								
0.2% Offset strength	≥ 225 N/mm <sup>2</sup>								
Elongation	≥ 35 %								
Impact test	NA								
Welding position	Horizontal/Flat position								
Welding polarity	DC-EP								
Shielding gas	98%Ar - 2%O <sub>2</sub>								
Welding current	Dia.0.8 mm	Dia.0.9 mm	Dia.1.0 mm	Dia.1.2 mm	Dia.1.6 mm				
	80-180A	120-200A	140-250 A	170-300 A	200-350A				
Packing	12.50 kgs standard other packing weight can be provided upon request.								