

## Stick electrode

**Features:** ■ Suitable for dissimilar-metal joint and underlaying on ferritic steels

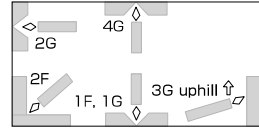
**Classification:** AWS A5.4 E309LMo-16

**Redrying Conditions:** 150~200°Cx0.5~1h

**Identification color:** 1st Silver, 2nd Blue

**Polarity:** AC, DCEP

## Welding Positions:



## Packaging data

φ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
2.6	300	2	20	19	300W, 95H, 330L
3.2	350	5	20	33	175W, 135H, 380L
4.0	350	5	20	54	175W, 130H, 380L
5.0	350	5	20	85	175W, 130H, 380L

## Composition (all-weld metal mass%)

	Typical (AC)	Guaranty <sup>a</sup>
<b>C</b>	0.03	0.04
<b>Si</b>	0.51	1.00
<b>Mn</b>	1.3	0.5~2.5
<b>P</b>	0.02	0.04
<b>S</b>	<0.01	0.03
<b>Ni</b>	12.9	12.0~14.0
<b>Cr</b>	23.5	22.0~25.0
<b>Mo</b>	2.1	2.0~3.0
<b>Cu</b>	0.07	0.75

Note: <sup>a</sup> Single values are maximum.

## Welding parameters (A)

φ mm	1F, 1G, 2F, 2G	3G uphill, 4G
2.6	50~85	45~80
3.2	70~115	65~110
4.0	95~145	85~135
5.0	135~180	-

## All-weld mechanical properties

	Typical (AC)	Guaranty
<b>0.2%YS (MPa)</b>	450	-
<b>TS (MPa)</b>	630	518min.
<b>EI on 4d (%)</b>	41	30min.
<b>IV 0°C (J)</b>	65	-

## Approvals

<b>ABS</b>	<b>MG</b>
<b>NK</b>	<b>KD309Mo</b>