



STAINCORD 309Mo-16



- ▶ All Positional, Rutile Type Stainless Steel Electrode
- ▶ Moisture Resistant Flux Coating/"Extra" Low Carbon Deposit
- ▶ Suitable for the Dissimilar Welding of Stainless Steel to Mild/Low Alloy Steels.

Identification

Coating - Grey

End Tip - Black

Imprint - 309LMo-16

Classifications

AS/NZS 1553.3 E309Mo-16 (Superseded)

AWS A5.4 E309Mo-16

AS/NZS 4854 ISO 3581B ES309LMo-16*

*New classification replaces AS/NZS 1553.3

Description & Applications

Staincord 309Mo-16 is an extra low carbon, rutile type electrode exhibiting superior all positional (except vertical down) performance with an improved moisture resistant coating for weld metal of high radiographic integrity. The smooth arc action of Staincord 309Mo-16, together with low spatter and excellent slag control/detachability, promotes exceptional weld appearance and profile.

Staincord 309Mo-16 is a Molybdenum bearing, highly alloyed 23Cr/12Ni/2.5Mo stainless steel electrode for welding matching 309 and 390Mo base metals. Major applications of Staincord 309 Mo-16 also involve the welding of a wide range of 300 and 400 series stainless steels to mild/low alloy steels. 309M is also suitable for general welding applications with alloyed and non-alloyed dissimilar ferrous metal combinations.

Operational Data

ELECTRODE SIZE (mm)	ELECTRODE LENGTH (mm)	WELDING CURRENT RANGE * (amps)	ARC VOLTAGE RANGE (volts)**
2.5	300	50 - 75	22
3.2	350	75 - 110	26

*Recommended for DC+ or AC (minimum 70 OCV) operation

** Voltage is determined by arc current and electrode arc length. Arc voltage shown are typical and are only to be used as a guide.

Typical All Weld Metal Chemical Analysis

C	Mn	Si	Cr	Ni	Mo	Fe
0.025	0.8	0.7	23.5	13.0	24	Bal

Typical All Weld Metal Mechanical Properties

Yield Stress	400 Mpa
Tensile Strength	670 Mpa
Elongation	38%

In as welded condition.

Packaging Data

ELECTRODE SIZE (mm)	PACKAGING (KG)		APPROX NO OF RODS PER KG	PART NUMBER
	Packet	Carton		
2.5	2.5	15	86	SC309MO25
3.2	2.5	15	55	SC390MO32

Storage Information

Products should be stored in dry conditions in original sealed undamaged packaging as supplied. The integrity of consumable products can be adversely affected by time and storage conditions and that the detail shown in the batch certificate is true at the time of packaging and is only valid for a LIMITED time. After that time the product may need to be reconditioned or checked to ensure it is suitable for the purpose it is intended to be used for.*

*NOTE: Refer to Welding Technology Institute of Australia (WTIA), technical 3. care and conditioning of arc welding consumables.