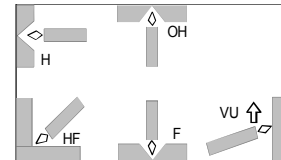


Shielded Metal Arc Welding

NC-39MoL
FAMILIARC
Lime titania type covered electrode for dissimilar metals
Classification: ASME / AWS A5.4 E309MoL-16
 JIS Z3221 D309MoL-16

Features : •Suitable for dissimilar-metal joint and underlaying on ferritic steels in stainless steel weld metal overlaying
 •Lower carbon content than **NC-39**
Redrying Conditions: 150~200°Cx0.5~1h

Welding Positions:

Chemical composition of all-weld metal (%) as per AWS

	C	Si	Mn	P	S	Ni	Cr	Mo
Example	0.029	0.51	1.28	0.024	0.005	12.65	23.08	2.29
Guaranty	≤0.04	≤0.90	0.5~2.5	≤0.04	≤0.03	12.0~14.0	22.0~25.0	2.0~3.0

Mechanical properties of all-weld metal as per AWS

	0.2%OS (MPa)	TS (MPa)	EI (%)	IV (J)
Example	450	630	41	0°C: 65
Guaranty	-	≥520	≥30	-

Recommended welding parameters

	2.6mm	3.2mm	4.0mm	5.0mm
F, HF, H	50~85A	70~115A	95~145A	135~180A
VU, OH	45~80A	65~110A	85~135A	-

Polarity

Example	AC
Guaranty	AC, DC-EP

Approvals

AB	NK
MG	KD309Mo

Packages

Dia. (mm)	Length (mm)	Weight per pack (kg)	Weight per carton (kg)	Weight per piece(g)
2.6	300	2	20	19
3.2	350	5	20	33
4.0	350	5	20	54
5.0	350	5	20	85