



# OK Tigrod 309MoL

GTAW

Bare, corrosion-resistant rod of the "309MoL" type. OK Tigrod 309MoL is used for the overlay welding of unalloyed and low-alloyed steels and for welding dissimilar steels such as 316L to unalloyed and low-alloyed steels when Mo is essential.

## Welding Current

DC (-)

PACKING/ORDERING INFORMATION			
Part Number	Dia (mm)	Per Pack (kg)	Pallet Weight (kg)
165416R150	1.6	5	1000
165420R150	2.0	5	1000
165424R150	2.4	5	1000
165432R150	3.2	5	1000

CLASSIFICATIONS	APPROVALS	TYPICAL ALL WELD METAL COMPOSITION (%)		TYPICAL MECH. PROPERTIES ALL WELD METAL	
EN 12072 W 23 12 2 L	DNV For C- & C/Mn-steels to 316L	C	<0.03	Yield Stress, Mpa	
		Si	0.5	400	
		Mn	1.6	Tensile Strength, Mpa	
		Cr	22.0	600	
		Ni	14.8	Elongation, %	
		Mo	2.7	40	
		Cu	<0.2	Charpy V	
		Test Temps, °C	Impact Values, J		
		+20	140		

