



# Shield-Bright 309MoL Xtra

FCAW

Designed for welding type 316 clad steels on the first pass in cladding steels or for welding dissimilar metals such as molybdenum containing austenitic stainless steels to carbon steels in the flat and horizontal position. SB309MoL Xtra is used in paper mills and in power plants. Carbon content 0.04% maximum. Weld beads are finely rippled and horizontal fillets have an essentially flat surface and equal leg length. Either pure CO<sub>2</sub> or mixed gas (75% Argon/25% CO<sub>2</sub>) can be used.

## Welding Current

DC (+)

## Shielding Gas

CO<sub>2</sub> or 75% Argon/25% CO<sub>2</sub>

PACKING/ORDERING INFORMATION			
Part Number	Dia (mm)	Carton Weight (kg)	Pallet Weight (kg)
VacPac			
35EX12248V	1.2	12.5	787.5
35EX16248V	1.6	12.5	787.5

CLASSIFICATIONS	TYPICAL ALL WELD METAL COMPOSITION (%)			TYPICAL MECH. PROPERTIES ALL WELD METAL		
	Gas	CO <sub>2</sub>	75%Ar/25%CO <sub>2</sub>		As Welded CO <sub>2</sub>	As Welded 75%Ar/25%CO <sub>2</sub>
<u>SFA/AWS A5.22</u>						
E309LMoT0-1/E309LMoT0-4	C	0.034	0.030	Yield Stress, Mpa Tensile Strength, MPa Elongation, %	559	559
<u>EN 12073</u>	Mn	1.4	1.7			
T23 12 2 L R C 3	Si	0.6	0.6		725	704
T23 12 2 L R M 3	Cr	22.5	22.8		39	30
	Ni	13.4	13.5			
	Mo	2.7	2.7			
	FN	20	23			

