

Key Facts

- Stable, well directed arc
- Smooth bead formation
- Clean weld edge
- Low spatter loss with easy slag removal
- Easy to operate
- Handy 1KG pack

Description

A rutile type electrode with low spatter, well directed arc and smooth running characteristics.

Classification

AWS A5.4: E 309Mo-16

Welding Positions

Flat, horizontal, vertical-up and overhead.

Markings & Identification

End tip Colour: Gold
End side Colour: Silver
Printing: GEMINI 309Mo

Applications

Suitable for welding corrosion resistant CrNoMo steels to themselves and to mild or low alloy steel. Can be used as a buffer layer for stainless cladding applications on non alloy steels.



Typical All Weld Metal Analysis

C - Carbon	Mn - Manganese	Si - Silicon
0.025%	0.8%	0.7%
Cr - Chromium	Ni - Nickel	Mo - Molybdenum
23.5%	13.0%	24
Fe - Iron		
Remainder		

Typical All Weld Metal Mechanical Properties

Yield Strength:	400N/mm ²
Tensile Strength:	550-650N/mm ²
Elongation (5xD):	>30%
Impact Strengths ISO-V	>40J @ +20°C

Packaging & Ordering Information

Size	Packet	Ctn	Current Range	Part Number
2.6mm	1kg	20kg	50-80	100009
3.2mm	1kg	20kg	70-110	100010