



PRODUCT DATA SHEET

STAINLESS STEEL ELECTRODES

Staincord 309Mo-16



SUMMARY

- All Positional, Rutile Type Stainless Steel Electrode
- Specifically Indicated for AISI 309Mo Type Alloys
- Features Moisture Resistant Coating

IDENTIFICATION

Coating - Grey **Tip** - Plain **Imprint** - E309Mo/E309LMo-16

CLASSIFICATION

- AS/NZS 4854-B - E309LMo-16
- AWS A5.4: E309LMo-16

DESCRIPTION AND APPLICATION

Staincord 309Mo-16 is a "state-of-the-art" formulation for highest quality all position stainless steel welding. The extra low carbon alloy is specifically indicated for AISI 309Mo type alloys, but is also ideal for joining mild/low alloy steel to a range of 300 and 400 series stainless steels. Features moisture resistant coating with extra smooth running, high arc stability, easy re-strike, excellent slag removal and bead appearance.

NOTES ON USAGE

1. Clean up the contaminations on the base metal, groove and pass to pass with stainless steel brush.
2. Maintain short arc length. Moving range should be controlled within 2.5 times of the electrodes diameter when you are welding with weave method.
3. Dry the electrodes at 250–300 °C for 60 minutes before using, then store in a hot box at 100–150 °C during welding process.
4. Use lower current to prevent from cracking and minimize base metal dilution.

OPERATIONAL DATA

ELECTRODE SIZE (MM)	ELECTRODE LENGTH (MM)	WELDING CURRENT RANGE *(A)
2.6	300	50 - 90
3.2	350	70 - 130

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

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

C	Cr	Ni	Mo	Mn	Si	P	S	Cu
0.25	22.5	13.5	2.4	0.90	0.65	0.34	0.016	0.16

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

Tensile Strength	630 MPa
Elongation	40%

PACKAGING DATA

ELECTRODE SIZE (MM)	PACKAGING (KG)		PART NO.
	PACKET	CARTON	
2.6	2.5	12.5	SC309M026TT
3.2	2.5	12.5	SC309M032TT

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