

# Stainless Steel SMAW Electrodes

## KE309LMo

AWS A5.4 E309LMo-16  
JIS Z 3221 ES309LMo-16

### Product Features:

- Lime titanium oxide type covered electrode for low carbon content stainless steel.
- All deposited weld metal contains approximately 2.5%Mo to get better strength, acid and heat resistance than 309L.
- Adequate Ferrite content to provide low crack sensitivity.

### Applications:

- Welding of SUS 309MoL stainless steels.
- Cladding or welding of SUS316, 316L stainless steel to carbon steel or low alloy steel.

Typical chemical composition of all weld metal (wt%)

C	Si	Mn	Ni	Cr	Mo
0.03	0.63	1.25	12.94	22.89	2.03

Typical mechanical properties of all weld metal

Tensile Strength N/mm <sup>2</sup>	Elongation %
650	40

Size (mm) & recommended welding parameters (A) AC or DC+

Diameter / Length	2.6/300	3.2/350	4.0/350	5.0/350
Flat position	50~85	85~120	115~150	150~200
Vertical / overhead position	50~80	75~105	95~120	----

### Note:

# ecoweld®

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