



FCW 309LMOP

*All positions 309LMo type
Flux cored wire*

Classification

AWS A5.22 : E309LMoT1-1/-4

ISO 17633-A : T 23 12 2 L P M21(C1) 1

Description & Applications

Metal flux cored wire for gas shielded (Ar + CO₂ or 100% CO₂) arc welding in all positions for stainless steel 309L type alloyed with Molybdenum and for heterogeneous assembly with stainless steel and low alloy steel with service temperature up to +350°C.

Main applications: Welding of stainless steels with similar composition, buffer layer and rebuilding before hardfacing.

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Cu	Nb	Co	P	S	N
Min			0.5	22.0	12.0	2.0						
Max	0.04	1.0	2.5	25.0	14.0	3.0	0.5			0.030	0.025	
Type	0.03	0.80	1.4	23.5	12.5	2.8	0.10	0.01	0.05	0.020	0.008	0.06

All Weld Metal Mechanical Properties

	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
Min	350	550	25	
Max				
Type	600	760	27	+20°C 50

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick out (mm)	
FCAW = +	1.2	130 - 270	25 - 35	12 - 25	ISO 14175 : M21 (Ar + CO ₂) C1 (100% CO ₂) 10-20 l/min



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