

AMERIARC

Ameri 309 MoA1

INTERNATIONAL CLASSIFICATIONS

AWS/ASME A 5.4 E 309LMo-16
ISO 3581: E 23 12 2 LR 32

DIN 8556: E 23.13.2 LR 26

DESCRIPTION & APPLICATION:

Ameri 309 MoA1 is Extra strong and tough stainless steel electrode for joining steels to stainless steels. It is moisture resistant coating provides sound porosity free deposits.

Most of the common types of stainless steel can be welded with this electrode without the loss of properties.

WELD METAL CHEMICAL ANALYSIS (TYPICAL WEIGHT %):

C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Fe
.02	.8	.7	.01	.02	25	14	3	.05	bal

Flux Color : Grey

TYPICAL MECHANICAL PROPERTIES:

Undiluted Weld Metal	Maximum Value Up to:
Tensile Strength	110,000 PSI (750 MPa)
Yield Strength	76,000 PSI (530 MPa)
Elongation	30%
Hardness	210HB

WELDING CURRENT & INSTRUCTIONS:

Recommended Current: DC Reverse (+) or AC

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Minimum Amperage	55	75	90
Maximum Amperage	75	110	140

PACKAGING & DIMENSIONS:

Dimensions	Diameter (mm)	2.5	3.25	4.0
	Length (mm)	12" (300)	14" (350)	14" (350)
Packaging	Electrodes /lb	8.8	8.8	8.8
	Electrodes / kg	4.0	4.0	4.0