

VALIANT

VALIANTWELD-309 Mo

AWS:A5.4:E309Mo-16 IS-5206:E23.12.2 R26

Valiantweld 309 Mo is a stainless steel yielding a weld deposit of 25 Cr-12Ni-2.5Mo, which has good oxidation resistance up to 1050°C . Ideally suited for welding 18-11 mo type steels to mild steel, welding the clad side of 18-11 Mo clad steels, overlays on ferritic steels, buffer layers etc.

CHEMICAL COMPOSITION

C	Mn	Si	Cr	Ni	Mo
0.07	1.50	0.50	23.5	13.0	2.4

MECHANICAL PROPERTIES

UTS (Kg/mm ²)	EI (L = 4D)%
62.2	33.3

WELDING PARAMETERS

	Size (mm)	Current (Amp.)
AC/DC (-)	4.00 X 350	110-140
	3.15 X 350	80-110
	2.50 X 350	60-80

APPLICATION

Ideally suited for AISI 316L grade steels for welding of dissimilar steels containing molybdenum to carbon steels.

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