



# KISWEL

## KISWEL K-309MoLT

### Classifications:

EN ISO 17633-A: 2008: T 23 12 L P C1 1  
EN ISO 17633-B: 2008: TS309LMo-F C1 1  
AWS A5.22-07: E309LMoT1-1

KS D 3612: YF-309MoLC  
JIS Z 3323: TS309LMo-FC1

### Typical Chemistry Composition of Weld Deposit:

C	Si	Mn	Cr	Ni	Mo
<0.04	<1.00	0.50 – 2.50	21.00 – 25.00	12.00 – 16.00	2.00 – 3.00

### Description:

- For welding dissimilar joints between Stainless Steels and Low-Alloyed Steels.
- It is also used for first layer of cladding providing a buffer layer.
- Wire has low spatter, easy slag removal, good weld soundness and provides good corrosion resistance.

### Typical Mechanical Properties:

Yield Strength (Mpa)	Tensile Strength (Mpa)	Elongation (%)
min. 350	Min. 550	min. 25

### Welding Parameters:

Wire Diameter	Shielding Gas	Current (A)		Voltage (V)	
		Min.	Max.	Min.	Max.
1.20 mm	CO <sub>2</sub>	150	200	22	29



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