



# KISWEL

## KISWEL T-309LMo

### Classifications:

EN ISO 14343-A: W 23 12 2 L  
AWS A5.9: ER309LMo

### Typical Chemistry Composition of Weld Deposit:

C	Si	Mn	Cr	Ni	Mo
<0.03	0.30 – 0.65	1.00 – 2.50	23.00 – 25.00	12.00 – 14.00	2.00 – 3.00

### Description:

- For welding dissimilar joints between Stainless Steels and Low-Alloyed Steels.
- Wire has good weld soundness and provides good resistance against cracking.

### Typical Mechanical Properties:

Yield Strength (Mpa)	Tensile Strength (Mpa)	Elongation (%)	Impact Value (J)
min. 350	Min. 550	min. 25	92 (0°C)

### Packaging:

**GTAW Wire** (Ø in mm): 1.60 MM / 2.00 MM / 2.40 MM / 3.20 MM in 5.00 Kg Packing

### Welding Parameters:

Wire Diameter	Shielding Gas	Current (A)		Voltage (V)	
		Min.	Max.	Min.	Max.
1.60 mm	Ar	90	160	11	17
2.00 mm		100	170	11	17
2.40 mm		100	200	13	20
3.20 mm		120	250	13	22



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