

## Exaton 309LMo

Exaton 22.15.3.L is an austenitic filler material for joining stainless steels to carbon steels or low-alloy steels and for overlay welding. It is used for MIG/MAG welding.

<b>Classifications Wire Electrode</b>	SFA/AWS A5.9 : ER309LMo (mod) EN ISO 14343-A : G 23 12 2 L EN 10088-1 : ~1.4435
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<b>Shielding Gas</b>	M12, M13 (EN ISO 14175)
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### Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
<b>ISO</b>			
As Welded	450 MPa (65 ksi)	610 MPa (88 ksi)	31 %

### Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	20 °C (68 °F)	95 J (70 ft-lb)
As Welded	-196 °C (-321 °F)	20 J (15 ft-lb)

### Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	V	Al
0.02	1.3	0.33	0.002	0.02	14.5	21.0	2.6	0.07	0.002

### Typical Weld Metal Analysis %

Cu	N	Nb	Co	B	Ta	FN WRC
0.08	0.07	0.01	0.05	0.0007	0.005	8

### Typical Wire Composition %

C	Mn	Si	S	P	Ni	Cr	Mo	V	Al
0.01	1.4	0.35	0.003	0.015	15.1	21.5	2.6	0.06	0.002

### Typical Wire Composition %

Cu	N	Nb	Ti	Co	B	Ta	W	FN WRC
0.1	0.06	0.01	0.002	0.05	0.001	0.005	0.02	10

### Recommended Welding Parameters

Wire Diameter	Current	Voltage	Wire Feed Speed
0.8 mm (0.030 in.)	40-120 A	15-19 V	4.0-8.0 m/min (157-315 in./min)
1.2 mm (0.047 in.)	150-260 A	24-29 V	3.0-10.0 m/min (118-394 in./min)
1.6 mm (1/16 in.)	230-350 A	25-30 V	3.0-5.0 m/min (118-197 in./min)