

OK Tigrod 309MoL

GTAW

W 23 12 2 L

Description

Bare, corrosion-resistant rod of the "309LMO" type. OK Tigrod 309MoL is used for the overlay welding of unalloyed and low-alloyed steels and for welding dissimilar steels such as 316L to unalloyed and low-alloyed steels when Mo is essential.

Welding current

DC -

Classifications

EN 12072

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Wire composition

C	Si	Mn	Cr	Ni	Mo	Cu
<0.03	0.5	1.6	22.0	14.8	2.7	<0.3

Typical mech. properties all weld metal

Yield stress, MPa	400
Tensile strength, MPa	600
Elongation, %	40

Charpy V

Test temps, °C	Impact values, J
+20	140

Approvals

DNV

For C- & C/Mn -steels to 316L

Packing data

Diameter, mm	Length, mm	Weight of rods/ box, kg
1.6	1000	5.0
2.0	1000	5.0
2.4	1000	5.0
3.2	1000	5.0