

LKE-309MoL-16



LINKWELD ALLOYS INC.

AWS	A5.4 E309MoL-16
EN	EN1600 E 23 12 L R 1 2
JIS	Z3221 D309MoL-16

Characteristics:

LKE-309MoL is a rutile electrode use as a buffer layer in welding acid resisting clad steels. With crack resistance and corrosion resistance at the high temperature due to higher Mo content.

Applications:

It is suitable for dissimilar metal welding of joining mild steel to stainless steel and steels difficult to weld.

Notes on Usage:

1. Dry the electrodes at 250-300°C for 60 minutes and keep at 100-150°C before use.
2. Use lower currents for dissimilar metals welding.
3. Keep the arc as short as possible.

Typical chemical composition of weld metal (wt%)

C	Mn	Si	P	S	Cr	Ni	Mo
0.03	1.00	0.75	0.03	0.015	22.5	13.20	2.50

Typical mechanical properties of weld metal

TS N/mm ²	EL %
598	40

Welding position:



Sizes and recommended current range (AC or DC <+>)

Diameter (mm)		2.0	2.6	3.2	4.0	4.8
Length (mm)		250	300	350	350	350
Amps	F	30-55	50-85	80-120	100-150	140-180
	V&OH	20-50	45-80	70-110	90-135	-
Weight per pack(kg)		4/5	4/5	5	5	5
Weight per carton (kg)		20	20	20	20	20