

# NST A-309MoL

AWS: A5.22-95: E309LMoT 1-4  
NS-EN ISO 17633-A: T 23 12 2 L P M1  
EN ISO 9606-1: FM5



**Flux cored wire for positional welding of dissimilar steels, i.e. carbon steel against stainless materials such as AISI 316 etc.**

## General description:

NST A-309MoL is a rutile flux cored wire for positional welding of stainless materials such as AISI 316 and similar against carbon steel.

The flux cored wire uses an Argon/CO<sub>2</sub> mixed shielding gas.

This ensures a user friendly and stable welding arc, less spatter, good visual bead appearance and smooth transition to the parent materials.

The newly developed slag system gives the welder better control of the weld pool and this wire can now be welded without weaving in all positions.

It is also suitable for use with ceramic backing for single sided welding.

NST A-309MoL is the right choice for cladding carbon steel with a stainless (Mo alloyed) material.

## Welding positions:



## Welding current:

DC+

## Gas flow:

15-23 l/min.

## Typical chemical composition of all-weld-metal:

C	Si	Mn	P	S	Cu	Ni	Cr	Mo	
0.027	0.57	1.39	0.021	0.006	0.26	12.8	23.28	2.48	

## Shielding gas:

Argon+ 18-25% CO<sub>2</sub>.

## Typical mechanical properties of all-weld-metal:

Yield and Tensile Strengths				
Yield Mpa(Rp0.2)	Tensile Mpa(Rm)	Elongation %		
503	653	30		

## Guidance - Ampere (DC+):

Electrode diameter			
Ampere / Volt			

## Packaging information:

0,9mm x 5,0kg D200  
1,2mm x 5,0kg D200  
1,2mm x 12,5kg D300

## Approvals:

DNV, CE

## Reference / date:

NST A-309MoL,  
English, 06.02.2018.