

Standards:

EN ISO 3581-A:	E 23 12 2 LR 32
EN 1600:	E 23 12 2 LR 32
AWS A 5.4:	E 309 Mo-26
Mat.-No.:	1.4459

Approvals:

TÜV, DB

capilla® 309 Mo**Product description:**

Rutile-basic coated stick electrode for fusion welding of similar or lower alloyed CrNiMo-steels;

Especially suitable for overlay weldings onto non-alloyed steels if an 18/8/2 CrNiMo alloy has to be realised in the first layer.

Scaling resistant up to 1050°C.

Applications:

Fusion welding and cladding of material such as:

1.4401, 1.4404, 1.4406, 1.4410, 1.4437, 1.4571, 1.4580;

Also suitable for dissimilar joints of high and low alloyed steels

Typical weld metal composition:

[wt. - %]

	C	Cr	Ni	Mo	Fe
Min.		23	11	2,5	
Max.	0,03	24	13	3,5	Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Tensile strength R_m :	650	[MPa]
Yield strength $R_{p0,2}$:	460	[MPa]
Yield strength $R_{p1,0}$:	-	[MPa]
Elongation (L=5d):	30	[%]
Impact strength (ISO-V):	55	[J]

Positions: all except PG

Redrying: 300°C/2h

Dimension:

Ø [mm]	Length [mm]	Welding current [A]
2,0	300	40 – 60
2,5	300	60 – 90
3,25	350	80 – 110
4,0	350	100 – 150
5,0	450	150 – 200

Polarity

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also available:

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Capilla 309 Mo MAG

Capilla 309 Mo WIG