GWELD
SEAL OF TRUST

GRINOX 9Mo

IDENTIFICATION
GRINOX 9Mo E309 Mo-16

CLASSIFICATION
AWS/SFA 5.4: E309Mo-16 IS: E23.12.2 R 26

DESCRIPTION
An extruded, rutile based heavy coated electrode giving 25 Cr / 12 Ni / 2.5 Mo type stainless steel deposit. The arc is soft & stable with easy strike and restrike. Low spatter and easily detachable slag. Weld bead is finely-rippled. Addition of Molybdenum improves tensile strength and corrosion resistance. Weld metal is resistant to temperatures upto 1100°C.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Cr	Ni	Mo
0.10 max	0.5 - 2.5	0.9 max	0.03 max	0.03 max	22.0 - 25.0	12.0 - 14.0	2.0 - 3.0

MECHANICAL PROPERTIES (RANGE)

TS (MPa)	EL (%) (L=4D)	CVN Impact Value	
		Temp	Joules
550 min	30 min	27°C	65

TYPICAL APPLICATIONS
- For welding AISI 309, 309 Mo, 316 type of stainless steels of steels clad with such materials.
- Also suitable for joining Molybdenum containing high alloyed and unalloyed steels.
- Used for welding difficult to weld steels and for building up carbon steel to improve its wear resistance.
- Applicable for For AISI 309, 309-Mo, 316 type stainless Steels or Molybdenum containing high alloyed steels and unalloyed steels.

WELDING PROCEDURE
The base metal should be free from oil, Grease or Dirt before welding. Keep a short arc and avoid weaving. Weld is to be cleaned with stainless steel brush.

WELDING POSITION :

PACKING PARAMETERS

Size (mm)	Length (mm)	AMPS AC / DC (+)	Packing / Box (kg)	Packing / Box (Pcs)
2.5	350	70 - 90	2 x 5 = 10	94 x 5 = 470
3.15 / 3.20	350	100 - 120	2 x 5 = 10	60 x 5 = 300

4	350	120 - 140	2 x 5 = 10	38 x 5 = 190
5	350	140 - 180	2 x 5 = 10	24 x 5 = 120