

## GEN 309LMO Welding Wire and Rod

GEN 309LMO is similar to ER309LMO with lower chromium and higher nickel content which is typically used to weld type 316 clad steels on the first pass in cladding steel as well as to weld dissimilar metals such as molybdenum-bearing stainless steels to carbon or low alloy steels.

### CONFORMANCES

AWS A5.9/A5.9M :  
 ASME SFA-A5.9 :  
 ISO 14343-B :

### AWS CHEMICAL COMPOSITION (TYPICAL)

%C	%Cr	%Ni	%Mo	%Mn
0.03 max	20.5 – 21.5	14.2 – 15.0	2.0 – 3.0	1.5 – 2.25

  

%Si	%P	%S	%Cu	Total Others
0.30 – 0.60	0.025 max	0.005 – 0.02	0.30 max	

### TYPICAL WELD METAL MECHANICAL PROPERTIES

Yield Strength : 56,000 psi  
 Tensile Strength : 85,000 psi  
 Elongation : 35 %

### TYPICAL WELDING PARAMETERS

Process	Diameter		Voltage	Amperage	Gas/Flux
TIG (GTAW)	1/16"	1.6 mm	14 – 17	90 – 130	100% Ar
	3/32"	2.4 mm	15 – 20	120 – 175	100% Ar
MIG (GMAW)	.035"	0.9 mm	29 – 33	160 – 190	98%Ar – 2%O <sub>2</sub>
	.045"	1.1 mm	29 – 33	180 – 220	98%Ar – 2%O <sub>2</sub>
Sub Arc (SAW)	.093"	2.4 mm	28 – 33	250 – 450	
	.125"	3.2 mm	29 – 34	300 – 500	

\*All parameters are suggested as basic guidelines only and will vary depending on joint design, number of passes and other factors.

IMPORTANT: SPECIAL VENTILATION AND/OR EXHAUST REQUIRED  
 BEFORE USE, READ AND UNDERSTAND THE SAFETY DATA SHEET (SDS) FOR THIS PRODUCT AND SPECIFIC INFORMATION PRINTED ON THE PRODUCT CONTAINER.

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