

- ▲ Ultra-Seal vacuum packs.
- ▲ Rutile Type, Stainless Steel Electrode.
- ▲ Outstanding Operator Appeal!
- ▲ Now with Improved Slag Lift!
- ▲ All Positional (except vertical down) Welding Capabilities.
- ▲ Advanced Moisture Resistant Flux Coating.

Classifications:

AS/NZS 1553.3: (old)	E309Mo-17.
AS/NZS 4854: (new)	B E309Mo-17
AWS/ASME-SFA A5.4:	E309Mo-17.

Description and Applications:

Satinchrome 309Mo-17 is a rutile type, high alloy stainless steel electrode manufactured by CIGWELD for the all positional (except vertical-down) fillet and butt welding of 24Cr/13Ni type stainless steels.

The features of Satinchrome 309Mo-17 include high AC arc stability, sound radiographic quality, smooth arc transfer characteristics, very low spatter levels and excellent bead shape and contour. The advanced moisture resistant (MR) flux coating provides improved resistance to start-of-run porosity.

Slag lift of Satinchrome 309Mo-17 is enhanced in all welding positions, it is self peeling and non-spitting.

Applications of Satinchrome 309Mo-17 include the single and multi-pass welding of matching 309 and 309L stainless steels. Satinchrome 309Mo-17 is also suitable for the dissimilar welding of other "300 series" austenitic stainless steels and selected "400 series" ferritic grades to mild or low alloy steels such as 403, 405, 410, 416, 420, 430, 430F-Se, 446 etc and BHP 3CR12.

Packaging and Operating Data:

AC (minimum 45 O.C.V.), DC+ polarity.

Electrode Size mm	Electrode Length mm	Approx No. Rods/kg	Current Range (amps)	Packet	Carton	Part No
2.5	300	52	40-70	2.5kg	15kg - 6 x 2.5kg	611692
3.2	350	30	75-110	2.5kg	15kg - 6 x 2.5kg	611693
4.0	350	19	110-150	2.5kg	15kg - 6 x 2.5kg	611694

COMPARABLE CIGWELD PRODUCTS:

Autocraft 309LSi GMAW wire
AWS A5.9: ER309LSi.

Comweld 309L Gas/TIG wire
AWS A5.9: ER309L.

Verti-Cor 309LT & FCAW wires
AWS A5.22: E309LT-1

APPROVALS:

American Bureau of Shipping AWS A5.4: E309Mo-17.

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

0.2% Proof Stress	500 MPa
Tensile Strength	620 MPa
Elongation	35%
CVN Impact Values	60 J av @ +20°C.

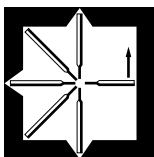
TYPICAL ALL WELD METAL ANALYSIS:

C: 0.05%	Mn: 0.75%	Si: 0.9%
Cr: 23.0%	Ni: 13.0%	Mo: 2.2%
S: 0.012%	P: 0.017%	

FERRITE NUMBER:

15.0 - 20.0 FN*

* - using Severn Gauge



All positional - except vertical down