

SATINCROME 309Mo-17
45
OCV

AC
DC+

- 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.
- Packed in Resealable Plastic Tubes.

Classifications:

ISO AS/NZS 4854: B ES309Mo-17
 AWS/ASME-SFA A5.4: E309Mo-17

Description and Applications:

Satincrome 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 Satincrome 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 Satincrome 309Mo-17 is enhanced in all welding positions, it is self peeling and non-spitting.

Applications of Satincrome 309Mo-17 include the single and multi-pass welding of matching 309 and 309L stainless steels. Satincrome 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.

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*

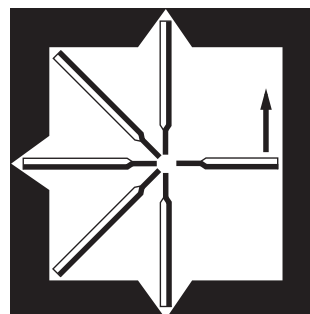
* - USING SEVERN GAUGE

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.

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: E309LT1-1



All positional -
except vertical down

Packaging and Operating Data:

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

Electrode Size mm	Length mm	Approx No. Rods/kg	Current Range (amps)	Packet	Carton	Part No
2.5	300	49	50-90	1.7kg	10.2kg - 6 x 1.7kg	611692N
3.2	350	27	60-120	1.9kg	11.4kg - 6 x 1.9kg	611693N
4.0	350	18	85-180	4.4kg	13.2kg - 3 x 4.4kg	611694N