

## SATINCROME 309Mo-17

### PRODUCT DATA SHEET



### RUTILE TYPE, HIGH ALLOY STAINLESS STEEL ELECTRODE

45  
OCV

AC  
DC+

### STAINLESS STEEL AND SPECIAL ELECTRODES

#### SATINCROME 309MO-17

- 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

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

## 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.

## 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

## PACKAGING & OPERATING DATA:

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

ELECTRODE SIZE (MM)	ELECTRODE LENGTH (MM)	APPROX NO. RODS/KG	CURRENT RANGE (AMPS)	PACK SIZE	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

## FERRITE NUMBER:

15.0 - 20.0 FN\*

\* - USING SEVERN GAUGE

## WELDING POSITIONS:

All positional - except vertical down.

