

## DATASHEET RW 309 LMO – MIG wire

### Description and Applications

Austenitic stainless steel welding wire similar to RW 309 L except to the addition of 2,5 to 3,0 % of Mo in order to increase the pitting corrosion properties in chloride containing environments. It is primary used for surfacing of parent metals to improve their corrosion resistance. Also often used for buffer layers when cladding with a RW 316LAWS and for dissimilar joints with C, Mn and low alloy steels.

### Rodacciai denomination and approximate equivalent with other standards

#### RW 309 LMO

EN ISO 14343-A:2009 G 23 12 2 L  
 EN ISO 14343-B:2009 ~ SS 309 L  
 AWS A5.9-2012 ~ ER 309 L

### Filler metal properties

Chemical composition (nominal) in %

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Co	Al	Ti	N	Ca	Nb	B	Ce
min		1,30	0,25			21,00	14,50	2,50					0,045				
max	0,020	1,80	0,60	0,015	0,025	22,00	15,50	3,50	0,30	0,30			0,080		0,050	0,003	

### Metal properties

The following data are typical for non-heat treated weld metal from MIG welding with M1 DIN EN ISO 14175 as shielded gas.

### Expected minimum mechanical properties of all weld metal

Temperature	°C	20
Yield strength, Rp 0,2	N/mm <sup>2</sup>	350
Tensile strength, Rm	N/mm <sup>2</sup>	550
Elongation, A5	%	25
Impact energy, ISO – V	J	50

### Packaging forms

Blue metallic wire baskets BS300 of 15 kg.

Plastic spools D300 of 12,5 kg for diam. 0,60 – 0,80 mm and of 15 kg for the other diameters.

Plastic spools D200 of 5 kg.

Drum packaging of about 150 kg for diameter 0,80 mm and of about 250 kg for the other diameters.

Diameters : 0,60 – 0,80 – 0,90 – 1,00 – 1,20 – 1,60 mm.