Stainless Steel Electrodes | Gemini 309Mo-16

Key Facts

- Stable, well directed arc
- Smooth bead formation
- Clean weld edge
- Low spatter loss with easy slag removal
- Easy to operate
- Handy 1KG pack

Description

A rutile type electrode with low spatter, well directed arc and smooth running characteristics.

Classification

AWS A5.4: E 309Mo-16

Welding Positions

Flat, horizontal, vertical-up and overhead.

Markings & Identification

End tip Colour: Gold
End side Colour: Silver
Printing: GEMINI 309Mo-16

Applications

Suitable for welding corrosion resistant CrNiMo steels to themselves and to mild or low alloy steel. Can be used as a buffer layer for stainless cladding applications on non alloy steels.



Typical All Weld Metal Analysis

C - Carbon	Mn - Manganese	Si - Silicon
0.04%	1.00%	0.60%
Cr - Chromium	**Ni - Nickel**	**Mo - Molybdenum**
23.50%	12.50%	2.50%

Typical All Weld Metal Mechanical Properties

Yield Strength:	400 MPa
Tensile Strength:	550-650 MPa
Elongation (5xD):	>30%
Impact Strengths ISO-V	>40J @ +20°C

Packaging & Ordering Information

Size	Packet	Ctn	Current Range	Part Number
2.6mm	1kg	20kg	50-80	100009
3.2mm	1kg	20kg	70-110	100010

Disclaimer: The above information is provided as a guide; actual welding current and voltage will depend on the welding machine characteristics, which will vary from model to model. Other variables include run length and size, plate thickness, operator technique and gas type (if used). The user must evaluate the process, application and recommended professional advice. Under no circumstance will Dynaweld or its affiliates be liable for misuse or application of products this is entirely up to the user's ability.