

Product Data Sheet



BRAND NAME VJ 309Mo

AWS/ASME Class E309Mo-16

SPECIFICATION SFA A5.4

Features and Applications :

VJ 309MO is a high-performance electrode that deposits a 25Cr-12Ni-2.5Mo weld metal, offering exceptional corrosion and oxidation resistance up to 1100°C. Ideal for welding Type 309 steels, chrome steels, and dissimilar metals, it ensures radiography-quality welds. Perfect for pressure vessels, heat exchangers, nuclear components, and industries like chemical, oil & gas.

CHEMICAL COMPOSITION :

All Weld Metal (%)			
TYPICAL	Max	TYPICAL	Max
C	0.120	Mn	0.50-2.50
Cr	22.0-25.0	Si	1.00
Ni	12.0-14.0	S	0.03
Mo	2.0-3.0	P	0.04
Cu	0.75		

MECHANICAL PROPERTIES OF WELD METAL

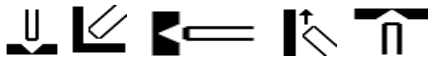
All Weld Metal - As Welded	
Properties	Typical
UTS (MPa)	550 Min
EI (%)	30 Min

DIMENSIONS & CURRENT DATA

Dimension (mm)	Current (A)		Packing (Pcs)
	Min	Max	Qty / Pkt
Dia x Length			
2.50 x 350	50	80	150
3.15 x 350	80	130	100
4.00 x 350	130	170	75
5.00 x 350	170	230	50

CURRENT : AC/DC (+)

WELDING POSITION:



OTHER DATA:

Redrying: The electrodes should be redried at 250°C for 1 hour.