NC-39MoL PREMIARC™

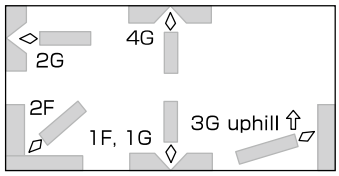
Stick electrode

Features: ▪ Suitable for dissimilar-metal joint and underlaying on ferritic steels

Classification: AWS A5.4 E309LMo-16

Redrying Conditions: 150~200℃x0.5~1h
Identification color: 1st Silver, 2nd Blue
Polarity: AC, DCEP

Welding Positions:



Packaging data

ϕ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
2.6	300	2	20	19	300W, 95H, 330L
3.2	350	5	20	33	175W, 135H, 380L
4.0	350	5	20	54	175W, 130H, 380L
5.0	350	5	20	85	175W, 130H, 380L

Composition (all-weld metal mass%)

	Typical (AC)	Guaranty [a]
C	0.03	0.04
Si	0.51	1.00
Mn	1.3	0.5~2.5
P	0.02	0.04
S	<0.01	0.03
Ni	12.9	12.0~14.0
Cr	23.5	22.0~25.0
Mo	2.1	2.0~3.0
Cu	0.07	0.75

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F, 2G	3G uphill, 4G
2.6	50~85	45~80
3.2	70~115	65~110
4.0	95~145	85~135
5.0	135~180	-

All-weld mechanical properties

	Typical (AC)	Guaranty
0.2%YS (MPa)	450	-
TS (MPa)	630	518min.
El on 4d (%)	41	30min.
IV 0℃ (J)	65	-

Approvals

ABS	MG
NK	KD309Mo