

IABCO EQ309LMo

Stainless steel strip for strip cladding

Product name	IABCO EQ309LMo
Classification EN ISO	14343-A: B 21 13 3 L 14343-B: BS 309LMoD
Material No.	-
Classification AWS	A5.9: Nearest EQ316L or EQ309LMo
Approvals	-
Applications	A 309LMo austenitic stainless steel strip used for cladding with both the electroslag and sub-arc processes. Most commonly used as a 60mm wide by 0.5mm thick strip. EQ309LMo strip will normally be used for the first layer in combination with EQ316L strip in a two, or three, layer procedure to produce a final 316L analysis deposit. The strip could also be used on its own to produce a nominal 316L deposit analysis in a single layer with the electroslag process. Typical applications include cladding large vessels used in the petrochemical, refinery and chemical industries.
Base materials	Suitable for cladding most pressure vessel and boiler steels. Typical steels to be clad will include CMn, CrMo and CrMoV.
Typical analysis of wire, weight %	C: 0.01 Si: 0.40 Mn: 1.90 Cr: 20.3 Ni: 14.2 Mo: 2.9
Typical heat treatment ⁽¹⁾	Actual welding procedure (including preheat and interpass temperature) will depend on the base material that is being clad.
Mechanical properties of weld deposit ⁽²⁾	-
Other products	Strip: IABCO EQ309L, IABCO EQ309LNb, IABCO EQ316L, IABCO EQ347. Flux: UNISCO 1944 (electroslag).

Notes (1) Application codes and project specifications should always be referred to for specific requirements.

(2) Actual mechanical properties will be dependent on specific welding procedure (including shielding gas, flux, PWHT etc) and should always be confirmed by approval of an appropriate welding procedure.