



Manufacturers of Custom Welding Lines for Resale  
www.selectrode.com

**SELECTRODE**  
**1131**  
309LMo-16

### INTERNATIONAL CLASSIFICATIONS

AWS/ASME A 5.4 E 309LMo-16      EN 1600: E 23.12.2 L R 32  
DIN 8556: E 23.13.2 LR 26      ISO 3581: E 23 12 2 LR 32  
NFA 81-343: EZ 23.13.2 LR 26

### FEATURES & APPLICATIONS

Wherever maximum ductility is required when joining dissimilar steels to themselves or to stainless steels.

Extra strong and tough stainless steel electrode for joining steels to stainless steels

- Highly recommended for joining hard to weld steels.
- Moisture resistant coating provides sound porosity free deposits.
- Slag is self-removing.
- Also available in TIG form as product code 6090.

### ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

**Microstructure:** Austenite with a ferrite content between 15 and 25%.

**Flux Color:** Grey

C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Fe
.02	.8	.7	.01	.02	25	14	3	.05	bal

### TYPICAL MECHANICAL PROPERTIES

#### Undiluted Weld Metal

Tensile Strength  
Yield Strength  
Elongation  
Impact Energy  
Hardness

#### Maximum Value Up to:

110,000 PSI (750 MPa)  
76,000 PSI (530 MPa)  
32%  
50J: 68°F (20°C)  
Brinell 219, Rockwell C 14

## WELDING CURRENT & INSTRUCTIONS

**Recommended Current:** DC Reverse (+) or AC

Diameter (mm)	1/16 (1.6)	5/64 (2.0)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Minimum Amperage	25	30	55	75	90
Maximum Amperage	35	50	75	110	140

**Welding Techniques:** Material to be welded should be clean of all contaminants. Maintain a short arc and use stringer beads rather than a weave technique.

**Welding Positions:** Flat, Horizontal, Vertical up, Overhead

**Deposition Rates:**

Diameter (mm)	Length (mm)	Weldmetal/ Electrode	Electrodes per lb (kg) of Weldmetal	Arc Time of Deposition min/lb (kg)	Amperage Settings	Recovery Rate
1/16 (1.6)	10" (250)	.13oz (3.6g)	125 (275)	55 (121)	30	100%
5/64 (2.0)	12" (300)	.14oz (4g)	114 (251)	47 (103)	40	100%
3/32 (2.5)	12" (300)	.3 oz. (9g)	50 (109)	35 (76)	65	100%
1/8 (3.25)	14" (350)	.7oz (20g)	22 (49)	21 (46)	95	100%
5/32 (4.0)	14" (350)	1 oz (29g)	15 (33)	18 (40)	120	100%

## APPROXIMATE ELECTRODE PACKAGING & DIMENSIONS

Diameter (mm)	1/16 (1.6)	5/64 (2.0)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Length (mm)	10" (250)	12" (300)	12" (300)	14" (350)	14" (350)
Electrodes / lb	67	42	28	13	9
Electrodes / kg	147	92	62	29	20