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DIN EN 14700 T 23 12 2 L R M 3 (C3)

CORODUR® TS 309 LMO

Flux cored wire with an alloyed core, suitable for joining difficult-to-weld steels and for corrosion-proof claddings. An austenitic weld metal (Cr Ni Mo 18/10/2) is obtained already in the first layer. The alloy is also suitable for welding buffer layers on plated metal sheets and for joining austenitic to ferritic steels which are subject to service temperatures of up to 350 °C. Due to its high alloy level CORODUR® TS 309 L Mo produces crack-proof welds. The addition of molybdenum ensures higher corrosion resistance and higher tensile-strength at elevated temperatures, as compared to the moly-free material 1.4829. The weld metal is heat resistant and non-scaling up to 1050 °C.



Dissimilar joints of: 1.4583 mit H I / H II, 17 Mn 4, StE 355. P235GH / P256GH, P295GH, P355N Buffering before cladding.

Joining of stainless steels to mild or low–alloyed steels at high dilution levels.

TYPICAL ALL WELD METAL ANALYSIS (%)						
C	Si	Mn	Cr	Ni	Mo	
0,03	0,8	1,4	23,0	13,5	2,8	
Tensile strength R _m Yie _{N/mm²} 760		ield strength _{N/mm²} 590	R _{p0,2} Elor	gation A ₅ % 32	Impact strength ^(J) 50 @ 20° C	

Other dimensions on request

CORODUR Fülldraht GmbH may change the characteristics of the wire without notice. Statements on composition and application are just for the applier's information. Statements on mechanical properties always refer to the all-weld-metal according to valid standards. We recommend the applier to check our products for their special application autonomously.