

TIG Welding Rod – OK Tigrod 309MoL

OK Tigrod 309MoL is an over-alloyed TIG welding wire designed for joining dissimilar steels. Its low carbon content and molybdenum addition provide excellent corrosion resistance and reliable performance.

OK Tigrod 309MoL is an extra low-carbon austenitic TIG welding wire (ER309MoL) containing approximately 22% chromium, 15% nickel, and 2.6% molybdenum. It is engineered for welding stainless steels and for joining dissimilar materials such as stainless to carbon or low-alloy steels where molybdenum enhances corrosion resistance.

The wire is suitable for both wrought and cast materials. Its austenitic structure with controlled ferrite content ensures crack resistance and stable weld quality.

Key features:

- Extra low carbon (L-grade) reduces intergranular corrosion risk
- Molybdenum alloyed for enhanced corrosion resistance
- Ideal for dissimilar metal welding (stainless to carbon steel)
- Stable arc and reliable welding performance
- Austenitic structure with approx. 8% ferrite

Key technical data:

- Yield strength: approx. 490–510 MPa
- Tensile strength: approx. 630–640 MPa
- Impact toughness: down to -60°C (approx. 65 J)
- Shielding gas: II (argon)

Typical applications:

- Joining stainless to carbon steel
- Maintenance and repair
- Process and offshore industries
- Corrosion-resistant piping and structures



Read more about the product here:

<https://john-dahle.no/product?number=1151320VM>