

RAAJCORED 309L

STAINLESS STEEL GAS SHIELDED FLUX CORED ARC WELDING WIRE

Classification : AWS: A5.22 E309L-T1
JIS Z 3323 TS309L-FC1

Description : Rutile type Gas shielded Flux cored arc welding wire, austenitic structure weld metal, smooth and stable arc, low spatter loss and easy slag remove. Low carbon content in weld metal to get good crack and inter-granular corrosion resistance. High welding performance, austenite weld metal contains adequate ferrite numbers to get good crack resistance, Good bead appearance, Easy to get smooth fillet size,

Typical Application :

- Suitable for welding of SUS309L steel.
- Welding of carbon steel or other high hardening alloys steels to stainless steel (Low carbon).
- Cladding or welding of stainless steel to carbon steels or low alloy steels.

TYPICAL ALL WELD CHEMICAL COMPOSITION (Wt. %)

C	Mn	Si	Ni	Cr
0.040	1.43	0.32	12.70	23.78

TYPICAL ALL WELD MECHANICAL PROPERTIES:

UTS (N/mm ²)	Elongation %
619	35.4

DIEMENSION, CURRENT CONDITION & RECOMANDED PARAMETERS

Size (mm)	Dia	1.20	1.60
Polarity		DC+	DC+
Ampere(A)	Flat and Horizontal position	150~250	200~300
	Vertical/overhead position	100~140	-----
Shield	Gas	CO ₂	CO ₂

Note: - Use General CO₂ Welding Machine with proper feed Roller pressure.