



## FCW 309LMo

### Flux Cored Wire

#### Classification

AWS A5.22 : E309LMo T0 -1/4  
EN ISO 17633-A : T23 12 L P M3 / C3

Material N° : 1.4459

#### Characteristics

Flux cored for welding used to weld on 316L stainless steels and for dissimilar joints between construction / mild steels and stainless steels. Intermediate layer for a 316L type cladding. Due to its high level of delta ferrite also used for repairs in maintenance welding. Highly crack resistant.

#### Applications

Dissimilar joining of Steel cladding in case 18-8 CrNi layer is required. Dissimilar joints, low alloy to stainless steels.

#### Base Materials

UNS	Alloy	EN	Material N°	UGINE
S 31600	316	X5CrNiMo17-12-2	1.4401	UGINOX 17-10 M
S 31603	316 L	X2CrNiMo17-12-2	1.4404	UGINOX 18-11 ML
S 31635	316 Ti	X6CrNiMoTi17-12-2	1.4571	UGINOX 17-11 MT

#### Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	P	S	Fe
0.030	0.80	1.40	23.00	13.50	2.80	0.08	0.022	0.008	base

#### All Weld Metal Mechanical Properties (Typical)

Conditions	UTS	YS	% Elg	Impact (KV)	
	R <sub>m</sub> (MPa)	Re (MPa)		Temp. °C	J
AW	760	590	34	+ 70	40

#### Welding Current & Instructions

Welding Mode	Ø Wire (mm)	Welding Mode			Shielding Gas ISO 14175
		Current (A)	Voltage (V)	Stick-out (mm)	
FCAW = +	1.2	120 - 240	23 - 30	15 - 20	M21(Ar+10-20 %CO <sub>2</sub> ) or CO <sub>2</sub> 18 - 20 l/min

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