



# FCW 309LP

All position 309L type  
Flux cored wire

## Classification

AWS A5.22 : E309LT1-1/-4

ISO 17633-A : T 23 12 L P M21(C1) 1

## Description & Applications

Flux cored wire for gas shielded (Ar + CO<sub>2</sub>) arc welding for 309L stainless steel and for dissimilar joining type 304 or 316 on low alloys steels. The high ferrite content allows an important dilution without cracks. Wire with rutile fast freezing to weld in all positions.

**Main applications:** Pressure vessels, maintenance and repair. Buttering before Low carbon cladding or Final hardfacing

## Typical Chemical Composition ( % )

| C    | Si   | Mn  | Cr   | Ni   | Mo   | Cu   | P    | S     | Fe   |
|------|------|-----|------|------|------|------|------|-------|------|
| 0.03 | 0.70 | 1.4 | 23.5 | 13.0 | 0.10 | 0.10 | 0.02 | 0.008 | Rem. |

## All Weld Metal Mechanical Properties

| R <sub>p0.2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> ( % ) | KV ( J ) |    |
|-------------------------|----------------------|----------------------|----------|----|
| 460                     | 580                  | 35                   | -60°C    | 40 |

## Welding Current & Instructions

| Welding mode | Wire Ø (mm) | Welding parameters |             |                | Shielding Gas   |
|--------------|-------------|--------------------|-------------|----------------|---|
|              |             | Current (A)        | Voltage (V) | Stick out (mm) |   |
| FCAW<br>= +  | 1.2         | 130 - 270          | 22 - 35     | 12 - 25        | ISO 14175 :<br>M21 (Ar/CO <sub>2</sub> )<br>10 - 20 l/min |

FT En-CN10-160211



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