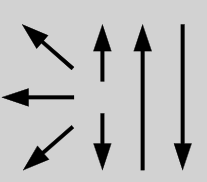


| Classification | | | | | |
|--|--|--|---|---------------------------|------|
| AWS A5.22 | | | | | |
| E309LT1-1 | | | | | |
| Characteristics and typical fields of application | | | | | |
| <p>Avesta FC 309L-T1 is a high-alloy 23Cr 13Ni wire primarily intended for surfacing on low-alloy steels and for dissimilar welds between mild steel and stainless steels. It provides the excellent usability with stable arc, less spattering, good bead appearance, and better slag removal.</p> <p>Avesta FC 309L-T1 is designed for all-round welding and can be used in all positions without cahnging parameter settings.</p> | | | | | |
| Base Materials | | | | | |
| Primarily used when surfacing unalloyed or low-alloy steels and when joining non-molybdenum alloyed stainless and carbon steels. | | | | | |
| Typical analysis of solid wire (wt.-%) | | | | | |
| C | Si | Mn | Cr | Ni | Mo |
| 0.03 | 0.60 | 1.50 | 23.2 | 12.8 | 0.02 |
| Ferrite Number ≈ 10 – 15 FN WRC 92 | | | | | |
| Mechanical properties of all-weld metal | | | | | |
| Heat treatment | Yield strength R _e N/mm ² | Tensile strength R _m N/mm ² | Elongation (L ₀ =5d ₀) | Impact work ISO-V KV J | |
| | MPa | MPa | % | - 20 °C | |
| As Welded | 390 | 550 | 35 | 50 | |
| Operating data | | | | | |
|  | | Polarity DC+ | Interpass temperature : Max. 150°C Heat Input: Max. 2.0 KJ/mm Shielding Gas : 100% CO ₂ Gas Flow rate: 20-25 L/min Wire stick out : 15-20 mm | | |
| Approvals | | | | | |
| ABS, BV | | | | | |
| Size, Packaging and Electrical Operating Data | | | | | |
| Size mm | Kg / Spool | | Amperage (A) | Voltage (V) | |
| 1.20 | 12.5 | | 150 – 240 | 22 – 30 | |