



**FALCON** Series  
WELDING PERFECTION

# FALCON E309LT1

FALCON E309LT1 is a quality rutile based stainless steel flux cored wire designed for all-positions welding with 100% CO<sub>2</sub> shielding. This product suitable for welding dissimilar metals such as joining ferritic and austenitic stainless steel, joining ferritic and martensitic metals and it is also use for buffer layer of clad steel. Produce smooth bright and flat weld bead with easy slag removal.

## Classifications

AWS A5.22	E309LT1-1
ASME SFA-A5.22M	E309LT1-1
EN ISO 17633-A:	T 23 12 L P C1 1
EN ISO 17633-B:	TS 309L-F C1 1

## Typical all weld metal composition, wt. %

	C	Mn	Si	Cr	Ni	Mo	P	S	Cu
AWS	≤0.04	0.5-2.5	≤1.0	22.0-25.0	12.0-14.0	0.75	0.040	0.030	0.75
Typical	0.023	1.34	0.53	23.71	13.31	0.042	0.021	0.002	0.03

## Mechanical properties of all well metal

	Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation (%)	Charpy V (J/°C)
AWS	as welded	-	520	30	-
Typical	as welded	-	565	40	-

## Operating Parameters

Polarity	Shielding	Current (A)	Voltage (V)	Gas flow
DCEP	100% CO <sub>2</sub>	120-260 (1.2mm)	22-36 (1.2mm)	20-25 L/min (1.2mm)
		200-300 (1.6mm)	25-38 (1.6mm)	20-25 L/min (1.6mm)

## Packing & Ordering Information

Wire sizes	Carton Weight	Pallet Weight	Packing method
1.2mm 1.6mm	12.5kg	1,050kg	Vacuum packed

- Proper wind-shielding measures are advisable to avoid porosity.
- Control inter-pass temperature within 16-100°C.
- Ensure base materials are free from moisture, dust, rust, and oil before welding.

A Quality Product of

