



**FALCON** Series  
WELDING PERFECTION

# FALCON E309MoLT1

FALCON E309MoLT1 is a quality stainless steel flux cored wire designed for all-positions welding with 100% CO<sub>2</sub> shielding. This product designed for welding 316 grade clad steels as initial pass in cladding steels and welding dissimilar metals such as joining ferritic and austenitic stainless steel with molybdenum content. Produce smooth bright and flat weld bead with easy slag removal.

## Classifications

AWS A5.22	E309LMoT1-1
ASME SFA-A5.22M	E309LMoT1-1
EN ISO 17633-A:	T 23 12 2 L P C1 2
EN ISO 17633-B:	TS 309LMo-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	21.0-25.0	12.0-16.0	2.0-3.0	0.040	0.030	0.75
Typical	0.023	1.34	0.53	21.90	12.80	2.63	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	25	-
Typical	as welded	-	565	38	-

## 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

