

Flux Cored Wire for Stainless Steel

KFW-309L

Classification

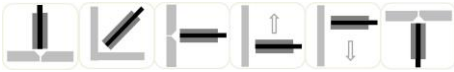
AWS	A5.22/A5.22M	E309LT1-1/4
JIS	Z3323	TS309L-FB1
EN	17633-A	T 23 12 L P C1/M21 2
GB	T17853	E309LT1-1/4

Shielding Gas : 100% CO₂ or Ar+20%CO₂

Applications and Features

- (1) Weld metal is austenitic structure with 22.5% Cr-12% Ni.
- (2) Excellent weldability and crack resistance due to proper ferrite content in the weld metal.
- (3) Stable arc, good slag removal, low spatters, X-ray quality welds and good penetration.
- (4) Suitable for joining 304 stainless steel to carbon steel or low alloy steel.

Welding position



Welding Instruction

- (1) For other instructions, please refer to Appendix D.
- (2) For extra information, please refer to Appendix F.

Typical Chemical Composition of Weld Metal (wt%)

C	Si	Mn	P	S	Cr	Ni
0.02	0.58	0.92	0.022	0.008	22.23	12.21

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation
N/mm ²	N/mm ²	%
574	411	37

Size and Suggested Operating Range (DC+)

Diameter (mm)		0.9	1.2	1.6
Current	Flat/H-fillet	110~150	150~220	200~300A
(A)	V-up	100~130	130~160	150~180A