

GTAW Flux Cored Wire for Stainless Steel

KFT-X309L

Classification

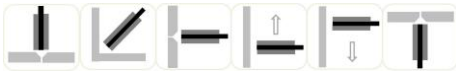
AWS A5.22/A5.22M	R309LT1-5
JIS Z3323	TS309L-RI
EN ISO 17633-B	TS309L-RI
GB T17853	R309LT1-5

Shielding Gas: 100% Ar

Applications and Features

- (1) KFT-X309L produces slag to protect the reverse side of the root pass from oxidation by the atmosphere and saves the cost for back shielding gases and gas purging downtime including the setting time for gas purging jigs.
- (2) Suitable for welding dissimilar materials such as mild steel to stainless steel.

Welding Position



Welding Instruction

- (1) Formation of key-hole during welding is very important in order to supply slag onto reverse side bead.
- (2) The melting rate of flux cored wire is higher than that of solid wire due to flux addition. The speed of wire feeding must be higher.
- (3) Only for root pass in single-side welding, not for cover pass.

Typical Chemical Composition of Weld Metal (wt%)

C	Si	Mn	P	S	Cr	Ni
0.02	0.66	1.41	0.021	0.008	22.20	12.66

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation
N/mm ²	N/mm ²	%
670	520	35

Size and Polarity (DC-)

Diameter (mm)	2.2
Length (mm)	1000