



# FCO 309L

309L type  
OPEN-ARC flux cored wire

## Classification

AWS A5.22 : E309LT0-3

ISO 17633-A : T 23 12 L U NO 3

## Description & Applications

OPEN ARC flux cored wire for welding of stainless steel 309L type and for heterogeneous assembly with stainless steel and low alloy steel with service temperature up to +350°C. Very low spatter and self-releasing slag. Especially used in the flat and half up / half down positions. Excellent weldability for outdoor job even when used in difficult weather conditions.

**Main applications:** Welding of stainless steels with similar composition, buffer layer and rebuilding before hardfacing.

## Typical Chemical Composition ( % )

	C	Si	Mn	Cr	Ni	Mo	Cu	P	S
Min			0.5	22.0	12.0				
Max	0.04	1.0	2.5	25.0	14.0	0.3	0.5	0.030	0.025
Type	0.03	0.80	1.75	24.5	13.0	0.10	0.10	0.020	0.008

## All Weld Metal Mechanical Properties

	R <sub>p0.2</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )	KV ( J )
Min	320	520	30	
Max				
Type	560	680	35	+20°C 45

## Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick out (mm)	
FCAW = +	1.2 1.6 2.0 2.4			25 - 45	-



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