



# FCT 309L

*TIG cored wire  
For root pass on dissimilar joint*

## Classification

AWS A5.22 : R309LT1-5

## Description & Applications

Flux cored wire for TIG welding for 309L stainless steel and dissimilar joint (steel with stainless steel). This product is dedicated to the root pass. Indeed this slag protects the reverse side from the oxidation by the atmosphere. Used for application with service temperature between -196°C and +400°C.

**Main applications:** Root pass for steel piping, petro chemical

**Base materials:**

UNS	Grade	EN 10088	N° Mat.
S30900	309	X15CrNiSi20-12	1.4828
S30453	304LN	X2CrNiN18-10	1.4311
S30908	309S	X12CrNi23-13	1.4833

## Typical Chemical Composition ( % )

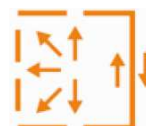
	C	Si	Mn	Cr	Ni	Mo	Cu	P	S
Min			0.5	22.0	12.0				
Max	0.03	1.2	2.5	25.0	14.0	0.75	0.75	0.04	0.03
Type	0.02	0.80	1.5	24.5	13.0	0.10	0.10	0.020	0.008

## All Weld Metal Mechanical Properties

	R <sub>p0.2</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )	KV ( J )
Min		520	30	
Max				
Type	460	580	35	+20°C 70

## Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Current (A)	Voltage (V)	
TIG = +	2.2	80 - 140	-	ISO 14175: I1 (Ar) 6 - 12 L/min



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