



FCW 309L

*High productivity 309L type
Flux cored wire*

Classification

AWS A5.22 : E309LT0-1/-4

ISO 17633-A : T 23 12 L R M21(C1) 3

Description & Applications

Flux cored wire for gas shielded (Ar + CO₂) arc welding for 309L stainless steel and for dissimilar joining type 304 or 316 on low alloys steels. The high ferrite content allows an important dilution without cracks. Flux cored wire with high productivity in down hand and fillet welding. Easy slag removal.

Main applications: Pressure vessels, maintenance and repair. Buttering before Low carbon cladding or Final 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	0.70	1.4	23.5	13.0	0.10	0.10	0.020	0.008

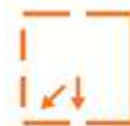
FN 23 (Feritscope)

All Weld Metal Mechanical Properties

	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
Min	320	520	30	
Max				
Type	460	580	32	-60°C 40

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick out (mm)	
FCAW = +	1.2	100 - 280	23 - 33	10 - 25	ISO 14175 : M21 (Ar/CO ₂) 12 - 20 l/min
	1.6	150 - 400	23 - 35	10 - 25	



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