



FCW 309M

*High productivity 309LMo type
Rutile flux cored wire*

Classification

AWS A5.22 : EC309L

ISO 17633-A : T 23 12 L M M12 1

Description & Applications

Rutile 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 +400°C. Welding bead without slag. Excellent weld metal quality and X-ray soundness. Mainly used in flat position.

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		0.35	1.0	23.0	12.0				
Max	0.03	0.65	2.5	25.0	14.0	0.3	0.5	0.030	0.025
Type	0.02	0.60	1.4	24.0	13.0	0.10	0.10	0.015	0.008

Ferrite FN : 15

All Weld Metal Mechanical Properties

	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)
Min	320	520	25
Max			
Type	470	580	35

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick out (mm)	
FCAW = + / pulsed	1.2 1.6	-	-	12 - 25	ISO 14175 : M12 (Ar + 2% CO ₂) 10-20 l/min

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