

Gas Shielded Type Flux Cored Wire

KF309L

AWS A5.22 E309LT1-1/4
JIS Z3323 TS309L-FC1

Product Features:

- Rutile type gas shield flux cored arc welding wire, austenite structure weld metal.
- Low spatter loss and easy slag removal.
- High welding performance, austenite weld metal contains adequate ferrite numbers to get good crack resistance.
- Low carbon content in weld metal to get good inter-granular corrosion resistance.
- Smooth fillet weld size.

Applications:

- Welding of SUS 309L stainless steel.
- Welding of carbon steels or other high hardening alloy steels to stainless steels (low carbon).
- Cladding or welding of stainless steels to carbon steels or low alloy steels.

Typical chemical composition of all-weld metal (wt%)

C	Si	Mn	Ni	Cr
0.04	0.32	1.43	12.70	23.78

Typical mechanical properties of all weld metal

Tensile Strength N/mm ²	Elongation %
619	35.4

Size (mm) & recommended welding parameters

Diameter		1.2mm	1.6mm
Polarity		DC+	DC+
Ampere (A)	Flat / Horizontal position	160~250	200~300
	Vertical / overhead position	100~140	----
Shielding Gas		CO ₂ / Mixed Gas	CO ₂ / Mixed Gas

Note:

- Use general CO₂ welding machine with proper feed roller pressure.

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50 Toegye-ro 18-gil, Jung-gu
Seoul, South Korea
www.ecoweldkorea.com