

E309LT1-1

AWS A5.22 E309LT1-1/4

EN ISO 17633-A : T 23 12 L P C1 2

Description:

E309LT1-1 is a stainless steel gas shielded flux-cored wire designed for welding of 22%Cr-12%Ni steel (SUS 309S), 18% Cr-8%Ni clad steel and dissimilar materials such as Cr-Mo steel or mild steel to stainless and build-up welding of carbon steel. It provides excellent usability with stable arc, less spattering, good bead appearance. The weld deposit has good crack and high temperature resistance. Used on 22%Cr-12%Ni steel (SUS 309S), 18% Cr-8%Ni clad steel and dissimilar materials welding.

Welding Position:



Diameters:

1.2mm, 1.6mm

Typical Mechanical Properties:

Tensile strength(MPa):	575
Yield strength(MPa):	--
Elongation(%):	34
Impact values(≥ 27)/(-196°C):	40

Typical Chemical Compositon:

C	Mn	P	S	Si	Ni	Cr	Mo	Cu
0.039	2.10	0.022	0.007	0.55	12.97	23.02	0.02	0.03

Welding Current:(DC+)

Diameter(mm)	1,2	1,6
Current/A	120-220	180-300
Voltage/V	20-32	20-32
Gas speed/(L/Min)	20-25	20-25

Note:

- 1.Shield gas: 100% CO₂ or 80% Ar+20% Co₂ .
2. Preheat before welding.
3. Interpass temperature: ≤ 80 °C