

## CHARACTERISTICS

- 1, All positional welding
- 2, Uniform bead formation
- 3, Multipass welding

## TYPICAL APPLICATIONS

- 1, Joining 309 stainless steel.
- 2, Dissimilar welds between carbon and low alloy steels to austenitic stainless steels.
- 3, 1st layer cladding of carbon steel if no columbium additions are required



<b>SIZE</b>	1.2mm
<b>AMPS</b>	160-200A

### CLASSIFICATION

AWS 5.22 Class E309LT1-1/4  
EN ISO 17633-A-T 23 12 L P C/M 1

### WELDING POSITIONS (ISO/ASME)



### EQUIVALENT TO

### CHEMICAL COMPOSITIONS (Wt%), ALL WELD METAL, TYPICAL

C	Mn	Si	P	S	Ni	Cr
0.028	1.04	0.53	0.025	0.009	12.77	23.73

### AVAILABLE SIZES (DIA.)

1.2mm

### PACKAGING DETAILS

5/15kg Spools

### CURRENT TYPE

DC+

### MECHANICAL PROPERTIES, ALL WELD METAL, TYPICAL

Condition	Shielding Gas	Yield Strength (mpa)	Tensile Strength (mpa)	Elongation(%)
AW	100% CO	461	586	38
	80% Ar+20% CO <sub>2</sub>			

Note:

Shielding gas: Gas speed 15-25L/Min

