

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



SIZE

1.2mm

AMPS

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)



PA/1G



PB/2F



PC/2G



PF/3Gu



PE/4G

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 ₂ or 80% Ar+20% CO ₂	461	586	38

Note:

Shielding gas: Gas speed 15-25L/Min

