

MIGINOX FC 309L

FCAW STAINLESS STEEL

AWS A/SFA 5.22 E309LT1-4

CLASSIFICATION:

EN ISO 17633-A

T 23 12 LP C1 2

T 23 12 LP M21 2

KEY FEATURES:

- An extra low carbon gas shielded stainless steel FCAW wire
- Typical 23Cr-13Ni type weld deposit
- Stable arc, low spatter and easy slag removal
- Excellent bead appearance
- Excellent crack and corrosion resistance
- High oxidation resistance up to 1100°C
- Radiographic weld quality

APPROVALS: CE

TYPICAL APPLICATIONS:

- Welding of AISI 309L type steels and similar grade materials, castings, pipes and tubes
- Joining stainless steel to carbon steel
- For overlays, buttering on carbon and low alloy steels


CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Cr	Ni	Mo
0.04 max	0.50-2.50	1.0 max	22.0-25.0	12.0-14.0	0.5 max


MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%
Specification	As Welded	520 min	30 min

PARAMETERS - PACKING DATA:

Ø, mm	Kg/Spool	
1.2	12.5	 DCEP STORAGE / HANDLING : Keep dry and follow handling instructions mentioned on the box
1.6	12.5	

All Positions, Except Vertical Down:



Shielding Gas	Gas Flow Rate, LPM
CO ₂	15-20
80Ar+20CO ₂	18-25

It can work with CO₂ sheilding gas.