

K-309LF

AWS E309LTO -1/4
JIS YF309LC
KS YF309LC

FOR STAINLESS STEEL

Typical applications

K-309LF is designed for MAG welding of low carbon 22%Cr-12%Ni stainless steel. Dissimilar joint welds ; of and between high-strength, mild steels and low-alloyed QT-steels, stainless, ferritic Cr-and austenitic Cr-Ni-steels, manganese steels. Cladding ; for the first layer of corrosion resistant weld claddings on ferritic-perlitic steels in boiler and pressure vessel parts up to fine-grained steel S500N.

Characteristics on Usage

- ① Wire is a titania type of flux cored wire for flat and horizontal position welding.
- ② It provides better weldability together with excellent corrosion resistance.
- ③ Wire has low spatter, easy slag removal and good weld soundness.
- ④ The shielding gas should be used 100%CO₂ and 80%Ar+20%CO₂ for welding.
- ⑤ Refer to page 150 for more information on usage.

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

Shielding Gas	C	Si	Mn	Cr	Ni
CO ₂	0.03	0.65	1.55	24.0	13.2
Ar+20%CO ₂	0.03	0.72	1.60	24.2	13.3

Typical mechanical properties of all-weld-metal

Shielding Gas	T · S N/mm ² {kgf/mm ² }	EI (%)
CO ₂	630 {64}	40
Ar+20%CO ₂	630 {65}	38

Sizes available and recommended currents (DC wire⊕)

Dia. (mm)	Amp.	Electrode extensin (mm)
1.2	100~220	10~20
1.6	160~260	15~20

Welding positions



Approved by

JIS