

FOR STAINLESS STEEL

AWS EC309L
JIS YF309LG
KS YF309LG

K-309LMT

Typical applications

K-309LMT is designed for MAG welding of low carbon 22%Cr-12%Ni stainless steels. It is suitable for automotive exhaust fabricators such as front pipe, bellows, flange. (AISI 409, 436, cladding and dissimilar joint welds)

Characteristics on Usage

- ① Slag quantity is almost the same as a solid wire and deposition rate is up to 20% higher than a solid wire's one.
- ② K-309LMT provides low spatter, excellent bead appearance and porosity resistance.
- ③ Weld metals contain comparatively much more ferrite in their austenitic, therefore they provide better weldability together with superior heat resistance, and corrosion resistance.
- ④ The shielding gas should be used 98%Ar+2%O₂ 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
Ar+2%O ₂	0.03	0.48	1.57	23.9	12.4

Typical mechanical properties of all-weld-metal

Shielding Gas	T · S N/mm ² {kgf/mm ² }	El (%)
Ar+2%O ₂	560 {57}	40

Sizes available and recommended currents (DC wire⊕)

Dia. (mm)	Amp.	Electrode extension (mm)
1.0	140~220	10~20
1.2	180~260	15~25

Welding positions



Approved by