

FOR STAINLESS STEEL

AWS E309LT1-1/4
JIS YF309LC
KS YF309LC

K-309LT

Typical applications

K-309LT is designed for MAG welding of low carbon 22%Cr-12%Ni stainless steels. 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 all-position welding.
- ② Weld metals contain comparatively much more ferrite in their austenitic, therefore they provide better weldability together with superior heat resistance, and corrosion resistance.
- ③ It is easy to use and operate with a powerful penetrating spray arc transfer, minimum spatter formation and self releasing slag.
- 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	0.60	1.40	23.6	13.1
Ar+20%CO ₂	0.03	0.80	1.92	23.8	13.3

Typical mechanical properties of all-weld-metal

Shielding Gas	T · S N/mm ² {kgf/mm ² }	EI (%)
CO ₂	550 {56}	40
Ar+20%CO ₂	600 {61}	38

Sizes available and recommended currents (DC wire⊕)

Dia. (mm)	Amp.	Electrode extensin (mm)
1.2	100~220	10~20
1.6	160~260	15~25

Welding positions



Approved by

ABS, BV, CWB, DNV, KR, LR, NK, RINA, TÜV, JIS
 (80%Ar+20%CO₂:CWB, TÜV)