

K-309MoLT

AWS E309LMoT1-1
JIS YF309MoLC
KS YF309MoLC

FOR STAINLESS STEEL

Typical applications

K-309MoLT is designed for MAG welding of low carbon 22%Cr-12%Ni-Mo 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 has higher tensile strength when compared to conventional K-309LT wire.
- ④ For Mo-alloyed claddings the product is necessary for the 1st layer.
- ⑤ The shielding gas should be used 100%CO₂ for welding.
- ⑥ Refer to page 150 for more information on usage.

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

Shielding Gas	C	Si	Mn	Cr	Ni	Mo
CO ₂	0.03	0.54	1.30	23.7	13.0	2.7

Typical mechanical properties of all-weld-metal

Shielding Gas	T · S N/mm ² {kgf/mm ² }	El (%)
CO ₂	670 {68}	32

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

KR, JIS