

# K-309T

**AWS E309T0-1/4**  
**JIS YF309C**  
**KS YF309C**

FOR STAINLESS STEEL

## Typical applications

K-309T is formulated for MAG welding of 22%Cr-12%Ni stainless steels. Typical applications is for welding of dissimilar steels, such as 304 to mild steel or low alloy steels.

## Characteristics on Usage

- ① K-309T is a titania type of flux cored wire for cladding and dissimilar joint welds.
- ② It is designed for operation in the flat position and for welding horizontal fillet welds.
- 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 100%CO<sub>2</sub> and 80%Ar+20%CO<sub>2</sub> 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 <sub>2</sub>	0.05	0.58	1.45	23.5	13.0
Ar+20%CO <sub>2</sub>	0.04	0.78	1.93	23.7	13.4

## Typical mechanical properties of all-weld-metal

Shielding Gas	T · S N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	EI (%)
CO <sub>2</sub>	590 {60}	36
Ar+20%CO <sub>2</sub>	610 {62}	35

## 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, DNV, KR, LR, NK, JIS