

ARCTEC® 309L FLUX CORED

Conforms to: AWS A5.22-95 E309LT1-1/T1-4
ASME SFA5.22
CWB to AWS A5.22-95 E309LT1-1/T1-4



GENERAL CHARACTERISTICS:

ARCTEC® 309L FLUX CORED is an all position flux cored wire for welding stainless steels with shielding gas. This wire has a fast freezing slag system, which facilitate out of position welding. The low carbon content increases resistance to intergranular corrosion without the addition of stabilizers such as columbium or titanium. It performs equally well when welding out of position and flat and horizontal.

APPLICATIONS:

ARCTEC® 309L FLUX CORED is designed for joining and cladding of types 309 stainless steels in wrought or cast form and is used extensively for welding type 304 to mild or carbon steel. Also used for welding 304 clad steels and for applying cladding to carbon steel.

MECHANICAL PROPERTIES:

Tensile Strength	Elongation	ft-lbs	Impact Value	
			Joule	Temperature
88,500psi(610Mpa)	35%-2"	44	60	-4° F (-20°C)

OPERATING PARAMETERS:

WELDING PROCESS: FCAW POLARITY: DC Reverse SHIELDING GAS: 100% CO₂ or 75% Argon /25% CO₂

Welding Parameters			
Diameter	Position	Amps	Volts
.035"	Flat	130-170	27-32
.035"	Horizontal	130-170	25-30
.035"	Vertical up	100-140	25-30
.035"	Overhead	100-140	25-30
.045"	Flat	140-180	25-30
.045"	Horizontal	140-180	25-30
.045"	Vertical up	100-140	25-30
.045"	Overhead	100-140	25-30
1/16"	Flat	250-290	28-33
1/16"	Horizontal	250-290	25-30

STANDARD SIZE AND PACKAGING:

Size		Packaging
.045" (1.2mm)	1/16" (1.5mm)	12" spools (15 Kg)

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Subject to change without notice

OHO2609051