

ARCTEC® E309L-0

Conforms to: AWS A5.22-95 E309LT0-3, ASME SFA5.22



a quality welding alloy

GENERAL CHARACTERISTICS:

ARCTEC® E309L-0 is a self shielding flux cored wire for cladding carbon steel. May also be used for joining 309 stainless steels and joining of dissimilar metals. This filler metal has a nominal composition of 25% chromium and 12% nickel. The low carbon content increases resistance to intergranular corrosion without the addition of stabilizers such as columbium or titanium. Shielding gas is not required.

APPLICATIONS:

ARCTEC® E309L-0 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 steel and for applying cladding to carbon steels.

PROCEDURE:

Clean weld area free from oil, grease, rust and other surface contaminants. Prepare joints as required.

MECHANICAL PROPERTIES:

Tensile Strength
84,500psi(589MPa)

Yield Strength
66,500psi(459MPa)

Elongation
34%-2"

OPERATING PARAMETERS:

WELDING PROCESS: FCAW

POLARITY: DC Reverse

SHIELDING GAS IS NOT REQUIRED.

Optimum Operating Parameters				
Diameter	Stickout	Wire Feed Speed	Amps	Volts
3/32" (2.4mm)	1"(25mm)	112"/min. (284cm/min)	250	26
3/32" (2.4mm)	1"(25mm)	136"/min. (345cm/min)	300	28
3/32" (2.4mm)	1"(25mm)	184"/min. (467cm/min)	350	29
3/32" (2.4mm)	1"(25mm)	221"/min. (561cm/min)	400	30

STANDARD SIZE AND PACKAGING:

Size	Packaging
3/32" (2.4mm)	25 Kg Coil

CALGARY FAX:(403)-250-7682	EDMONTON: (780)-484-4896	VANCOUVER: (604)-596-2940	WINNIPEG: (204)-663-7955
PHONE:(403)-250-9355	(780)-484-3304	(604)-596-6207	(204)-663-9182

The seller makes no warranties, express or implied, including, but not limited to, the implied warranties of merchantability and fitness for a particular purpose, except as expressly stated in seller's contract, delivery slip or invoice form. Technical data and suggested application are provided to assist you in making your own evaluations and decisions and should not be interpreted as expressed or implied warranties. Mechanical properties are typical or average values obtained by testing and comparing many heats of the same alloys. Minimum and maximum values are noted accordingly and are not intended for specific purposes.

Subject to change without notice

OHO011200/072