

Classifications

AWS A5.22-2012 : E309HT1-1

Description

- K-309HT is designed for MAG welding of high carbon 22%Cr-12%Ni stainless steels(STS 309) and recommended to be use for high temperature service (about 600°C)
- It is a titania type of flux cored wire for all-position welding and has excellent feedability and increased creep resistance at elevated temperature.
- The weld metal contains optimum ferrite contents in their austenitic micro structures and their weldability is excellent with lower crack susceptibility.

Welding positions



Polarity & shielding gas

- CO₂: 100% CO₂ (15~20ℓ/min)
- DCEP (DC+)

Typical chemical composition of all-weld metal (%)

Shielding gas	C	Si	Mn	Cr	Ni	FN
CO ₂	0.06	0.74	1.43	23.45	12.39	14

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J) -40°C	Remarks
AWS A5.22 Example	446	min. 550 583	min. 30 38	37	CO ₂

Notes on usage and welding condition

- Refer to page 313 for more information on usage
- When heat input is excessive, base metal will be bended or distorted due to the bad heat conductivity. Therefore, perform welding with selecting proper heat input

Package

Dia. (mm)	0.9	1.2	1.6
Spool (kg)	5, 12.5, 15		