

Flux Cored Welding Wire

K-309LF

Austenitic Stainless welding wire (Low C, Dissimilar joints)

Classifications

EN ISO 17633-A:2010	: T 23 12 L R C1/M21 3	KS D 3612-2016	: YF-309LC
EN ISO 17633-B:2010	: TS 309L-F C1/M21 0	JIS Z 3323-2007	: TS309L-FB0
AWS A5.22-2012	: E309LT0-1/4		

Description

- Dissimilar joint welds ; of and between high-strength, mild steels and low allowed 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.
- Wire is a titania type of flux cored wire for flat and horizontal position welding and it provides better weldability together with excellent corrosion resistance.
- Wire has low spatter, easy slag removal and good weld soundness.

Welding positions



Polarity & shielding gas

- CO₂: 100% CO₂ (15~20ℓ/min),
Mix: Ar+20% CO₂ (15~25ℓ/min)
- DCEP (DC+)

Typical chemical composition of all-weld metal (%)

Shielding gas	C	Si	Mn	Cr	Ni	FN
CO ₂	0.03	0.60	1.42	23.30	13.17	5~12 & 11~16
Mix	0.03	0.75	0.45	23.50	13.30	

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J) -30℃	Remarks
AWS A5.22		min. 520	min. 30		
EN ISO 17633-B	min. 320	min. 520	min. 25		
Example	420	560	37	43	CO ₂
	430	570	38	50	Mix

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		

Approvals

DNV*GL, JIS

* Please refer to our homepage(www.kiswel.com) for further detailed information regarding approvals.