

Flux Cored Welding Wire

K-309LMT

Austenitic Stainless welding wire (Muffler, Dissimilar joints)

Classifications

EN ISO 17633-B:2010 : TS 309L-M M13 0
AWS A5.9-2017 : EC309L

KS D 3612-2016 : YF-309LG
JIS Z 3323-2007 : TS309L-MA0

Description

- K-309LMT is designed for MAG welding of low carbon 22%Cr-12%Ni stainless steels and It is suitable for automotive exhaust fabricators such as front pipe, bellows, flange (AISI 409, 436 and dissimilar joint welds)
- Slag quantity is almost the same as solid wire and deposition rate is up to 20% higher than solid wire's one.
- K-309LMT provides low spatter, excellent bead appearance and porosity resistance.
- Weld metals contain comparatively much more ferrite in their austenitic, therefore they provide better weldability together with superior heat resistance, and corrosion resistance.

Welding positions



Polarity & shielding gas

- Mix: Ar+2% O₂ (15~25ℓ/min)
- DCEP (DC+)

Typical chemical composition of all-weld metal (%)

Shielding gas	C	Si	Mn	Cr	Ni	FN
Mix	0.03	0.50	1.65	23.90	12.60	18

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J) -30°C	Remarks
AWS A5.9		min. 520	min. 30		
EN ISO 17633-B		min. 520	min. 25		
Example	440	560	40	50	Mix

Notes on usage and welding condition

Dia.(mm)	1.2	Stick-out
Current	PA/1G	180 ~ 260
(Amp.)	PC/2G	(22 ~25)

Package

Dia. (mm)	1.2	1.6
Spool (kg)	5, 12.5, 15	
Pailpack (kg)	100	

Approvals

JIS

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