

Classifications

EN ISO 17633-B:2010 : TS 309L-M M13 0
 AWS A5.22-2012 : EC309L

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

Description

- K-309LMTS 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-309LMTS 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	Ti
Mix	0.03	0.47	1.60	23.40	13.40	0.50

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J) -30℃	Remarks
JIS Z 3323		min. 520	min. 25		
Example	450	570	42	60	Mix

Notes on usage and welding condition

Dia.(mm)	1.2	Stick-out
Current F (PA/1G)	180 ~ 260	(15 ~ 20mm)
(Amp.) HF (PC/2G)	(22 ~ 25)	

Package

Dia. (mm)	1.2	1.6
Spool (kg)	5, 12.5, 15	
P/pack (kg)	100	

Approvals

JIS

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