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WT-309LP

AWS A5.22 E309LT1-1/4

JIS Z3313 YF309LC

KS D3612 YF309LC

FOR STAINLESS
STEEL

Applications

WT-309LP is suitable for welding of 22%Cr-12%Ni steel and heat resistant steel and dissimilar joint such as a stainless steel to carbon steel of low alloy steel.

Under layer welding on claded side groove claded stainless steel or carbon steel where stainless steel weld metal is overlaid.

Characteristics on Usage

- 1) This is a rutile type flux cored wire for all-position welding.
- 2) It provides the excellent usability with stable arc, less spattering, good bead appearance, better slag removal, and less quantity of welding fume. comparable to solid wire.
- 3) The weld metal contains optimum ferrite contents in their austenitic structures, Therefore their weld ability is excellent with lower crack susceptibility.

Notes on Usage

- 1) Use 100% CO₂ gas or Ar+20~25% CO₂ gas.
- 2) The optimum flow of CO₂ for shielding is 20~25ℓ/min.
- 3) Protect the weld with a screen to prevent blowholes caused by wind where the wind velocity is 2m/sec and more.
- 4) Keep the distance between tip & base metal at 15~25mm.
- 5) For multi layer welding, keep preheat and inter-pass temperature below 150°C.

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Typical chemical composition of all-weld-metal (%) (Shielding gas : CO₂)

	chemical composition(%)							
	C	Si	Mn	P	S	Cr	Ni	Mo
AWS	≤0.04	≤1.0	0.5~2.5	≤0.04	≤0.03	22~25	12~14	≤0.5
WT-309LP	0.03	0.6	1.3	0.022	0.006	23.2	12.8	0.02

Typical mechanical properties of all-weld-metal (Shielding gas : CO₂)

	Tensile strength (N/mm ²)	Elongation %	Impact value (J)	
			0°C	-18°C
AWS	≥520	≥30	-	-
WT-309LP	584	41	-	48

Size available and recommend welding parameters (DC+)

Position		Dia	1.2(.045)	1.6(1/16)
			Current(A)	
Flat	Current(A)		180~220	200~280
Horizontal Fillet			180~220	200~280
Vertical up			120~160	160~220

Welding positions



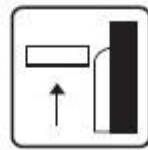
1G



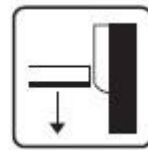
2F



3G



V-UP



V-DOWN



4G