

# HANKOOK WELDTEK CO.,LTD

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## WT-309MoL

AWS A5.22 E309LMoT1-1/4

JIS Z3313 YF309LMoLC

KS D3612 YF309LMoLC

FOR STAINLESS  
STEEL

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### Applications

WT-309MoL is suitable for welding of 22%Cr-12%Ni-2.5%Mo stainless steel.

Main uses are for the applications of resistance to heat and corrosion and for the joining of stainless steels to mild or low alloy steels.

### 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) Weld metals contain comparatively much more ferrite in their austenitic, therefor they provide better weldability together with superior heat resistance, and corrosion resistance.

### Notes on Usage

- 1) Use 100% CO<sub>2</sub> gas or Ar+20~25% CO<sub>2</sub> gas.
- 2) The optimum flow of CO<sub>2</sub> 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 : CO<sub>2</sub>)**

	chemical composition(%)							
	C	Si	Mn	P	S	Cr	Ni	Mo
AWS	≤0.04	≤1.0	0.5~2.5	≤0.04	≤0.03	21~25	12~16	2~3
WT-309MoL	0.02	0.6	0.9	0.02	0.006	22.4	13.1	2.2

**Typical mechanical properties of all-weld-metal (Shielding gas : CO<sub>2</sub>)**

	Tensile strength (N/mm <sup>2</sup> )	Elongation %	Impact value (J)	
			0°C	-20°C
AWS	≥520	≥25	-	-
WT-309MoL	552	29		59

**Size available and recommend welding parameters (DC+)**

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

**Welding positions**



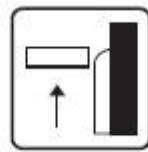
1G



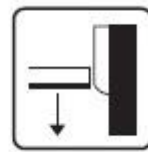
2F



3G



V-UP



V-DOWN



4G