

SW-309LNS Cored

TYPE : Metal-Cored

AWS A5.9 / ASME SFA5.9 EC309L
JIS Z3323 TS309L-MA0
EN ISO 17633-A-T 23 12 L M M

Applications

Main uses are for thin plate stainless steels and for the welding of automotive mufflers in 22%Cr-12%Ni stainless steels.

Characteristics on Usage

SW-309LNS Cored is a metal type stainless steel flux cored wire for welding of 22%Cr-12%Ni steel, heat resistant cast steel and for the joining of chrome nickel clad steels to Cr-Mo steel or mild steel. This wire is designed for flat and horizontal fillet welding. Its weld metal contains ferrite in austenitic structure, it gives excellent weldability, good corrosion and heat resistance.

Notes on Usage

① Use with 100% Ar or Ar + 2~5% O₂ gas.

Welding Position



1G (PA) 2F (PB)

Current

DC +

Shielding Gas

Ar/Ar+2~5%O₂

Typical Chemical Composition of All-Weld Metal (%) (Shielding Gas: 100% Ar)

C	Si	Mn	P	S	Cr	Ni
0.03	0.65	1.80	0.020	0.010	24.0	13.0

Typical Mechanical Properties of All-Weld Metal (Shielding Gas: 100% Ar)

TS MPa(lbs/in ²)	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
590 (85,600)	45	-20 (-4)	60 (44)

Approval

I Packing(Including Ball Pac)

Dia. (mm)	1.2	1.6	Spool(kg)	5	12.5	15
(in)	.045	1/16	(lbs)	11	28	33

Sizes Available and Recommended Currents (Amp.)

Size mm(in)	1.2 (.045)
F & HF	170~270