

Supercored 309L

TYPE : Rutile

AWS A5.22/ASME SFA5.22 E309LT0-1/-4
JIS Z3323 TS309L-FB0
EN ISO 17633-A-T 23 12 L R M/C 3

Applications

Supercored 309L is designed for the welding of dissimilar metals such as stainless steels and carbon steels or stainless steels and low alloy steels.

Characteristics on Usage

Supercored 309L which contains a high ferrite level in its austenitic structure has excellent heat and corrosion resistibility. It has a good stable arc and excellent slag removal properties.

Notes on Usage

① Use with 100% CO₂ or Ar + 20~25% CO₂ gas.

Welding Position



1G 2F
(PA) (PB)

Current

DC +

Shielding Gas

CO₂/Ar+20~25%CO₂

Typical Chemical Composition of All-Weld Metal (%) (Shielding Gas: 100% CO₂)

C	Si	Mn	P	S	Cr	Ni
0.03	0.70	1.50	0.025	0.010	23.5	12.5

Typical Mechanical Properties of All-Weld Metal (Shielding Gas: 100% CO₂)

TS MPa(lbs/in ²)	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
600 (87,000)	35	-20 (-4)	50 (37)

Approval

I Packing(Including Ball Pac)

TÜV, CE, DB, BV, DNV, GL, LR	Dia. (mm) (in)	0.9 .035	1.2 .045	1.6 1/16	Spool(kg) (lbs)	5 11	12.5 28	15 33
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Sizes Available and Recommended Currents (Amp.)

Size mm (in)	0.9 (.035)	1.2 (.045)	1.6 (1/16)
F & HF	120~180	150~220	240~300