

## AA 309LNb

**CATEGORY** FCAW Flux-Cored

**TYPE** Rutile flux cored stainless steel welding wire with exceptional Weldability for use with M21 and Co2

**APPLICATIONS** Cladding mild and low alloyed steels in offshore and or chemical plants in case AISI 347 or AISI 321 are required as clad layer

**PROPERTIES** Smooth drop transfer and stable arc with no spatter losses.  
Excellent productivity and weldability, better wetting properties compared to solid wires.  
Excellent weld metal quality and X-ray soundness and excellent slag removal.  
Excellent for use in position and down hand as well.  
High resistance against moisture pick up

**CLASSIFICATION**

AWS	A 5.22: E 309LCb T0-1
EN ISO	17633-A: TZ 23 12 Nb RM 3
DIN: W.Nr.	1.4556
DIN	8556: 23 13 Nb

**SUITABLE FOR** For steel cladding applications when AISI 347 or 321 is required in the first layer

**APPROVALS** CE approved

**WELDING POSITIONS:**



**ALL-WELD METAL ANALYSES %**

C	Mn	Si	Cr	Ni	Nb	S	P
0.03	1.40	0.70	23.0	12.5	0.80	0.08	0.020

**MECHANICAL PROPERTIES**

Heat treatment	R <sub>P0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact energy (J) ISO-V			Hardness HRc / HV
				+20C	0C	-20C	
AW with M21	480	650	35	>50			

AW = as welded

**WELDING PARAMETERS PACKING**

D (mm)	Welding Parameters			Packing		
	Voltage (V)	Current (A)	spool type	kg / spool	kg / pallet	
1.2	23-35	100-270	K-300	15	1080	
1.6	23-37	150-400	K-300	15	1080	

**REDRYING TEMPERATURE** 150°C / 24hr