FLUXINOX 309L-PF

OERLIKON

Cored Wires
Stainless and Heat resistant steels

Fluxinox 309L-PF is an alloyed rutile flux cored wire for joining high-alloyed Cr and Cr-Ni-(Mo) steels to unalloyed steels, as well as for depositing austenitic stainless cladding. The highest operating temperature for dissimilar joints is 300 °C. The weld metal is non-scaling up to 850 °C. Preheating and interpass temperatures should be calculated according to the base metal used. Fluxinox 309L-PF exhibits outstanding, almost spatter-free, welding properties and produces finely rippled flat and smooth welds which are free of undercut. Very easy slag removal. Due to its fast-freezing slag, Fluxinox 309L-PF is used for welding in the horizontal (PD), overhead (PE) and vertical-up (PF) positions.

Classification	
AWS	A5.22: E309LT1-4 / E309LT1-1
EN	12073: T 23 12 L P M 1 / T 23 12 L P C 1

Approvals	Grades
GL	
LRS	
TÜV	

Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Cu	N	Ferrite
$ 0.04	1.50	0.60	-	-	24	13	-	-	-	-	12-20

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm^2	Tensile Strength N/mm^2	Elongation A5 (%)	Impact Energy ISO - V (J) - 60 °C	Hardness
As Welded	≥ 320	≥ 520	≥ 30	≥ 32	-

Gas test: Acc. To EN 439: M21

Shielding Gas: Acc. To EN 439: M21 or C1

Materials

A312 TP309S; carbon steel to stainless steels joint

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+

Packaging data: K300 kg. 16

Diameters	1.2mm					

Diam.	15 kg Spool
1.2mm	OERFI309L-PF12

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