

SW-309L Cored

AWS A5.22 / ASME SFA5.22 E309LT1-1/-4
EN ISO 17633-A-T 23 12 L P M/C 2

TYPE : Rutile

Applications

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

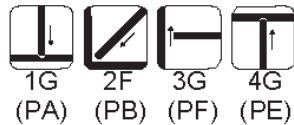
Characteristics on Usage

SW-309L Cored is a flux cored wire for all position welding to be used with CO₂ or Argon + CO₂ mixed shielding gases. This wire contains a high ferrite level in its austenitic structure thus providing better weldability together with superior heat and corrosion resistance. As high amounts of alloying elements are added, it is suitable for the welding of dissimilar joints where dilution from ferritic (mild and low alloy) steel takes place.

Notes on Usage

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

Welding Position



Current

DC +

Shielding Gas

CO₂ or Ar+20~25% CO₂

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

C	Si	Mn	P	S	Cr	Ni
0.03	0.65	1.30	0.025	0.010	23.0	12.3

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

TS MPa	EL (%)	Temp. °C	CVN-Impact Value J
590	40	-20	50

Approval

KR, ABS, LR, BV, GL, NK,
DNV, TÜV, CWB, CE, DB, CRS

I Packing

Dia. (mm) 1.2

Spool(kg) 15

Sizes Available and Recommended Currents (Amp.)

Size mm	1.2
F & HF	180~220
V-up,OH	120~160

Diam.	15 kg Spool
1.2mm	HKSW30912

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