

FLUX CORED WIRE : STAINLESS STEEL

SARTHAK SS 309L(E 309LT1-1)

AWS-A/SFA5.22E309LT1-1

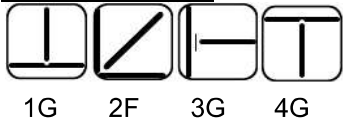
Applications

SARTHAK SS 309L (E 309LT1-1) is suitable for the welding of dissimilar metals such as stainless steel and carbon steel or stainless steel and low alloy steel.

Characteristics on Usage

SARTHAK SS 309L(E 309LT1-1) is a stainless steel flux core welding wire for all position welding with co2 gas shielding. It gives the 23% Cr and 12% Ni weld deposit with excellent all around performance and resistance to chemical corrosion. Weld metal is of radiographic quality with easy slag removal and low spatters.

Welding Positions



Recommended Stick Out

15-20mm

Shielding Gas

Carbon Dioxide (CO₂) shielding

Chemical Composition Of Weld Metal

Element	C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo %	Cu %
Typical Values	0.030	1.60	0.65	0.010	0.030	23.20	12.75	0.05	0.10
Spec. Reqd.	0.04 Max	0.5 – 2.50	1.00 Max	0.030 Max	0.040 Max	22.0 - 25.0	12.0-14.0	0.5 Max	0.5 Max

Mechanical Properties Of Weld Metal

Property	U.T.S. (N/mm ²)	ELONGATION (L = 4d) %
Typical Values	600	36
Spec. Reqd.	520 Min	30 Min

Welding Parameters (DC + VE)

Diameter (mm)	Flat		Vertical - Up		Overhead	
	(A)	(V)	(A)	(V)	(A)	(V)
1.20	160-210	26-30	120-210	22-26	160-210	26-30
1.60	190-250	26-30	160-250	21-27	190-250	26-30

Packing

12.5 kgs. vaccum packed plastic spool.