



# MIGINOX FC 309L

FCAW STAINLESS STEEL

AWS A/SFA 5.22 **E309LT1-1/4**

## CLASSIFICATION:

**EN ISO 17633-A**

T 23 12 LP C1 2

T 23 12 LP M21 2

## KEY FEATURES:

- An extra low carbon gas shielded stainless steel FCW wire
- Typical 23Cr-13Ni type weld deposit
- Stable arc, low spatter and easy slag removal
- Excellent bead appearance
- Excellent crack and corrosion resistance
- High oxidation resistance up to 1100°C
- Radiographic weld quality

## APPROVALS: CE

## TYPICAL APPLICATIONS:

- Welding of AISI 309L type steels and similar grade materials, castings, pipes and tubes
- Joining stainless steel to carbon steel
- For overlays, buttering on carbon and low alloy steels

## CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:



C	Mn	Si	Cr	Ni	Mo
0.04 max	0.50-2.50	1.0 max	22.0-25.0	12.0-14.0	0.5 max

## MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%
Specification	As Welded	520 min	30 min

With mixed gas chemical composition and mechanical properties will be higher.

## PARAMETERS - PACKING DATA:

Ø, mm	Kg/Spool		
1.2	12.5	 <b>DCEP</b>  <b>STORAGE / HANDLING :</b> Keep dry and follow handling instructions mentioned on the box	All Positions, Except Vertical Down: 
1.6	12.5		

Shielding Gas	Gas Flow Rate, LPM
CO <sub>2</sub>	15-20
80Ar+20CO <sub>2</sub>	18-25