



FCAW STAINLESS STEEL
MIGINOX FC 309L

STAINLESS STEEL GAS SHIELDED FLUX CORED WIRE FOR DISSIMILAR STEEL JOINING



CLASSIFICATION : AWS A/SFA 5.22 EN ISO 17633-A

E309LT1-1/4 T 23 12 L R C/M 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

WELDING POSITION :



DCEP

Shielding Gas	Gas Flow Rate, LPM	Stickout, mm
CO ₂	10-20	10-20
80Ar+20CO ₂	18-25	10-20

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

STORAGE / HANDLING :

Keep dry and follow handling instructions mentioned on the box

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt% :

	C	Mn	Si	Cr	Ni	Mo	S	P
Specification	0.04 max	0.50-2.50	1.0 max	22.0-25.0	12.0-14.0	0.5 max	0.03 max	0.04 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	Voltage, V	Amperage, A	Kg/Spool
1.2	22 - 32	120 - 300	12.5
1.6	24 - 34	200 - 360	12.5

EQUIVALENT :

SMAW Electrode: **Betanox DL**

GMAW Wire: **Miginox 309L**

GTAW Wire: **Tiginox 309L**