K-309LT

FLUX CORED ARC WELDING
CONSUMABLE FOR
AUSTENITIC STAINLESS STEEL

KISWEL

Description

- K-309LT is suitable for dissimilar-metal joint and underlaying on ferritics steels.
- Weld metal contains comparatively much more ferrite in their austenitic structure, therefore they provide better weldability together with superior heat resistance, and corrosion resistance.
- It is easy to use and operate with a powerful penentrating spray arc transfer, minimum spatter formation and self releasing slag.

Classification

- EN ISO 17633 A : T 23 12 L P C1/M21 1
- EN ISO 17633 B : TS 309L-F C1/M21 1
- AWS A5.22 : E309LT1-1/4

Typical Chemical Composition of Weld metal (wt.%)

	C	Si	Mn	Cr	Ni	Mo	FN
AWS A5.22	<0.04	<1.0	0.5-2.5	22.0-25.0	12.0-14.0	<0.75	-
100%CO_2	0.03	0.60	1.12	23.70	13.20	0.01	11-16
80%Ar+20%CO_2	0.03	0.75	1.20	23.90	13.20	0.01	11-16

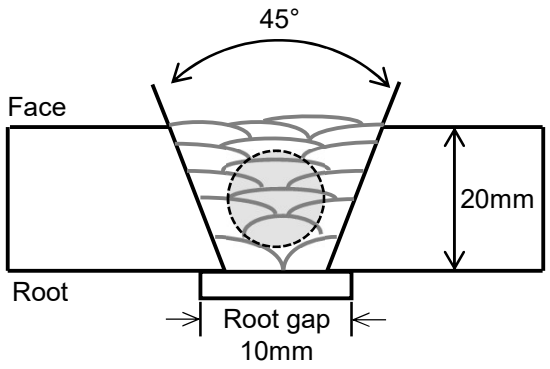
Shielding Gas

- 100%CO_2 (15~25ℓ/min)

Welding position



All Weld Metal Test Specimen



Base metal	SM490(Buttering)
Diameter	1.2mm
Current / Voltage	200A / 31V
Stick out	20mm
Travel Speed	32 CPM
Welding Position	PA / 1G

Typical Mechanical Properties of Weld metal

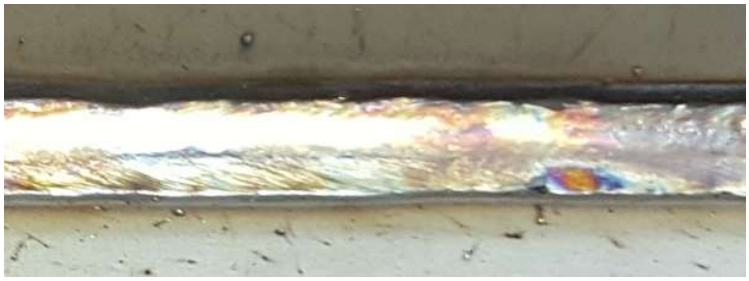
	Y.S (MPa)	T.S (MPa)	El. (%)	I.V (J) @ -30℃	Shielding Gas
AWS A5.22	-	>520	>30	-	CO_2
K-309LT	430	560	42	45	

Optimum Welding Conditions

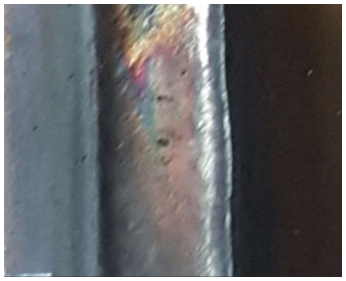
Current (A)	160	200	240
Voltage (V)	28	31	34

■ Bead appearance

H-Fillet



Vertical up



■ Packaging (Size and Weight)



Dia. (mm)	0.9, 1.0, 1.2, 1.4, 1.6
Weight (kg)	5, 12.5, 15
Pail pack(kg)	-

■ Handling and Storage

- **Once flux cored wire picked up moisture, it cannot be dried at high temperature, unlike covered electrode.**
- **If a wire was left in a wire feeder in a high-temperature high - humidity atmosphere in summer season, a wet environment in rainy season or a dew fall environment at night in winter was unpacked, the wire should be kept in an area of low humidity.**

  ※ Temp. below 30℃ relative humidity below 60%

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