

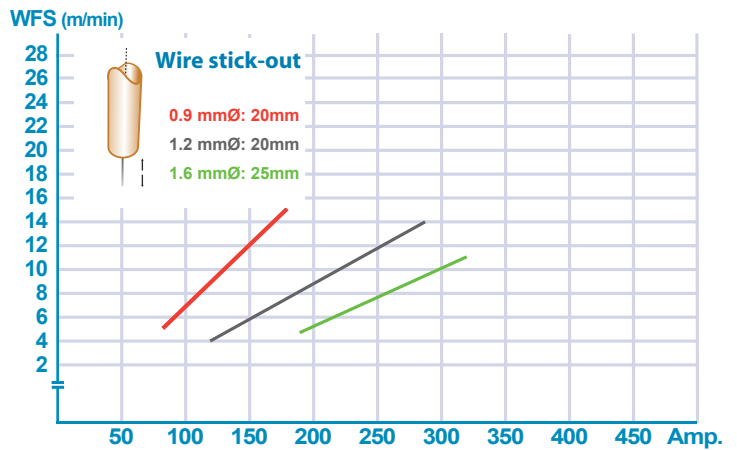
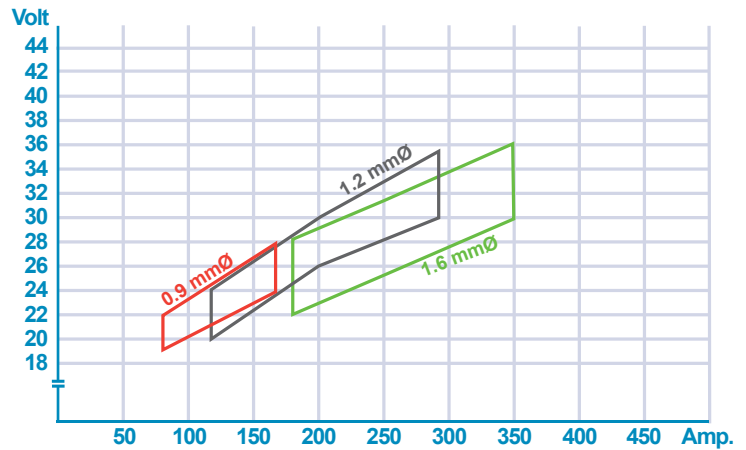
80%Ar - 20%CO₂ / 100%CO₂
 EN ISO 17633-A T 23 12 L R C/M 3
 AWS A5.22 E309LT0-1/-4
 EN 1.4332

Description and Application

This is a rutile flux cored wire which operates with very stable, spatter free arc producing bright, smooth weld bead surfaces and self releasing slag.

This wire deposit low carbon weld of about 24%Cr-13%Ni. It is designed for dissimilar welding such as welding stainless steel to mild steel or low alloy steel. The wire also suitable for the first layer on mild or low alloy steel prior to overlaying with PREMIARC™ DW-308L or PREMIARC™ DW-308LP

Recommended Parameter Range, for flat position*



Typical Chemical Analysis (wt. %)*

C	Si	Mn	P	S	Ni	Cr	Mo	N	Nb	FS	FN	FNW
0.02	0.70	1.40	0.019	0.005	12.6	23.9	-	-	-	13.2	>18.0	19.9

Typical Mechanical Properties*

	R _e (MPa)	R _m (MPa)	A ₅ (%)	CV (J)-20°C
Guarantee	min.320	min.520	min.30	43

* The above values and parameters are for all weld metal produced using Ar+CO₂ shielding gas

Welding Positions



Approvals

LR	DNV	BV	GL	ABS	R.M.R.S	Others
SS/CMn	309L	309L	4332S	MG	-	TÜV,DB,CWB
Dup/CMn						