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SpecMet CSF-309L(P)

AWS A5.22 E309LT1-1/4
KS D 3612 YF309LC
JIS Z 3323 TS309L-FB1
EN ISO 17633-A T 23 12 L P C1[M21] 1 - ISO 17633-B TS 309L-F C1[M21] 1

Applications

CSF-309L(P) is suitable for welding of 22%Cr-12%Ni steel and heat resistant steel and dissimilar joint such as a stainless steel to carbon steel of low alloy steel. Under layer welding on claded side groove claded stainless steel or carbon steel where stainless steel weld metal is overlaid.

Characteristics

- (1) CSF-309L(P) is flux cored wire and designed for Fillet & H-F(All-position) welding with CO₂ gas Shielding.
- (2) It provides the excellent usability with stable arc, less spattering, good bead appearance, better slag removal, and less quantity of welding fume comparable to solid wire.
- (3) Is containing Ferrite of a reasonable quantity and crack-resistance, intergranular corrosion resistance, mechanical properties of weld metal is superior.
- (4) Shield gas is 100% CO₂ or Ar+CO₂ gas.

Notes on Usage

- (1) The optimum flow of CO₂ for Shielding is 20~25l/min.
- (2) Protect the weld with a screen to prevent blowholes caused by wind where the wind velocity is 2m/sec and more.
- (3) Keep the distance between tip & base metal at 15~25mm.

Typical Chemical Composition of Weld Metal (%) (shielding gas: 100% CO₂)

	C	Mn	Si	P	S	Cr	Ni	FN
309L	0.03	1.51	0.56	0.015	0.015	23.6	12.8	22
309LP	0.03	1.33	0.64	0.019	0.006	23.6	13.0	21

Typical Mechanical Properties of Weld Metal (%) (shielding gas: 100% CO₂)

	YS N/mm ² (MPa)	TS N/mm ² (MPa)	EL (%)	IV (J) 0° C
309L	427	580	39	48
309LP	427	585	38	50

Size and Recommended Current Range (AC or DC+)

Dia mm (in)	Current (A)	Volatage (V)	Welding Speed (cm/min)
1.2 (0.045)	150~300	24~33	20~60
1.6 (0.062)	200~400	24~33	20~60

Approval : CSF-309L : ABS, BV, DNV, GL, KR, LR, NK / CSF-309LP : ABS, BV, DNV, LR