

PRODUCT NAME

Supercored 309L

CONFORMANCES

- **AWS** : A5.22 ASME SFA5.22 E309LTO-1-4
- **JIS** : Z3323 TS309L-FB0
- **EN** : ISO 17633-A-T 23 12 L R M/C 3

FEATURES

- Welded with 100% CO2 and Ar+20-25% CO2 shielding gas
- Current: DC+
- High deposition rate and efficiency
- Suitable for flat and horizontal fillet positions.

APPLICATIONS

- Buffer layer welding for cladding, overlays
- Dissimilar welds between carbon, low alloy steels to stainless steels
- Welding 23.5%Cr-13% Ni stainless steel

CHEMICAL COMPOSITION

	C	Si	Mn	P	S	Cr	Ni	Mo
100% CO2	0.03	0.50	1.50	0.02	0.01	23	12.5	0.05
Ar+20-25% CO2	0.03	0.60	1.60	0.02	0.01	23.5	12.5	0.05

MECHANICAL PROPERTIES

	TS MPa(Lbs/in ²)	EL (%)	Temp °C(°F)	CVN-impact value J(ft.lbs)	Ferrite number
100% CO2	570(79,750)	35	-20 (4)	45(33)	18-20
Ar+20-25% CO2	580(82,650)	34	-20 (4)	40(30)	18-20

DIAMETER/PACKAGING

Diameter Mm (in)	Spool	Pac
1.2(0.045)	5Kg	-
	12.5kg	-
	15kg	-