

ULTRA SS309LT1-1

FLUX CORED WIRE

AWS A/SFA 5.22
SS309LT1-1

CLASSIFICATION:

- EN ISO 17633-A
- T 23 12 L R C/M 1
- TS309LT1-1
- AWS A/SFA 5.22
- SS309LT1-1

TYPICAL APPLICATIONS:

- Heat exchangers
- Furnace parts
- Dissimilar metal welding
- Petrochemical industry
- Power plants
- Stainless steel and carbon steel joining

KEY FEATURES:

- All position capability
- Radiographic quality weld
- Rutile type gas shielded FCW wire
- Easy slag removal, smooth weld bead
- Suitable for single and multi-pass welds
- Low fumes, Minimal spatters, High deposition rate

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL WT (%):

C – 0.04	Mn – 1.7	Si – 0.5	Cr – 23.0	Ni – 13.5	
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MECHANICAL PROPERTIES OF ALL WELD METAL:

Condition	UTS, Mpa	YS at 0.2% offset, Mpa	EL%	CVN Impact, J at -
As Welded	580	430	26	52

PARAMETERS & PACKING DATA:

Ø x L mm	Amperage, A
1.2	130-280
1.6	200-360

DCEP(Electrode Positive)

Use 1-2 volts lower when using mix shielding gas

Available in Vacuum Pack of 15 kg wire layer wounded on Plastic Spool.



DCEP

Electrode Positive

All positions except vertical down



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mix shielding gas