

SFC-309L

AWS A5.22 E309LT1-1
JIS Z3323 TS309L-FC1
EN ISO 17633-A T 23 12 L P C/M 2

FLUX CORED WIRES FOR STAINLESS STEEL

DESCRIPTION :

SFC-309L is a rutile flux cored tubular wire for all-positional welding using pure CO₂ or Argon CO₂ mixed shielding gas. It performs with smooth arc transfer, low spatter level, fine ripple, fast freezing slag, easy control of weld pool and good hot crack resistance.

APPLICATIONS :

Suitable for welding dissimilar metals such as ferritic and austenitic stainless steels, as well as for joining ferritic martensitic steels. It is also used for buffer layers of clad steels.

NOTE ON USAGE :

1. Use DC (+) polarity.
2. Maintain a higher welding speed in order to get enough penetration in the down hand welding position.

WELDING POSITION:



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :(Shielding Gas: 100% CO₂)

Weld Metal Analysis :

Carbon (C)	0.031
Manganese (Mn)	1.56
Silicon (Si)	0.51
Phosphorus (P)	0.018
Sulphur (S)	0.013
Nickel (Ni)	12.62
Chromium (Cr)	23.62

TYPICAL MECHANICAL PROPERTIES OF WELD METAL:(Shielding Gas: 100% CO₂)

TS N/mm ²	572
EL%	40

TYPICAL IMPACT VALUES :

IV -60°C J	35
------------	----

APPROVALS :

ABS,BV,CCS,CE,DNV · GL,LR,JIS

SUGGESTED WELDING PARAMETERS (DC <->)

Parameters	1.2mm		1.6mm	
	F, HF	V-UP, OH	F, HF	V-UP, OH
Welding Position	F, HF	V-UP, OH	F, HF	V-UP, OH
Voltage (Volt)	23 ~ 33	25 ~ 30	27 ~ 32	--
Current (Amp)	130 ~ 220	120 ~ 200	200 ~ 300	--