

SW-309L Cored

TYPE : Rutile

AWS A5.22 / ASME SFA5.22 E309LT1-1/-4
JIS Z3323 TS309L-FB1
EN ISO 17633-A-T 23 12 L P M/C 2

Applications

SW-309L Cored is designed for the welding of dissimilar metals such as stainless steels and carbon steels or stainless steels and low alloy steels.

Characteristics on Usage

SW-309L Cored is a flux cored wire for all position welding to be used with CO₂ or Argon + CO₂ mixed shielding gases. This wire contains a high ferrite level in its austenitic structure thus providing better weldability together superior heat and corrosion resistance. As larger amounts of alloying elements are added, it becomes suitable for the welding of dissimilar joints where dilution from ferrite steel takes place.

Notes on Usage

① Use with 100% CO₂ or Ar + 20~25% CO₂ gas.

Welding Position



1G (PA) 2F (PB) 3G (PF) 4G (PE)

Current

DC +

Shielding Gas

CO₂/Ar+20~25%CO₂

Typical Chemical Composition of All-Weld Metal (%) (Shielding Gas: 100% CO₂)

C	Si	Mn	P	S	Cr	Ni
0.03	0.65	1.30	0.025	0.010	23.0	12.3

Typical Mechanical Properties of All-Weld Metal (Shielding Gas: 100% CO₂)

TS MPa(lbs/in ²)	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
590 (85,600)	40	-20 (-4)	50 (37)

Approval

KR, ABS, LR, BV, GL, NK,
DNV, TÜV, CWB, CE, DB,
CRS

I Packing(Including Ball Pac)

Dia. (mm) 0.9 1.2 1.6
(in) .035 .045 1/16

Spool(kg) 5 12.5 15
(lbs) 11 28 33

Sizes Available and Recommended Currents (Amp.)

Size mm (in)	0.9 (.035)	1.2 (.045)	1.6 (1/16)
F & HF	130~180	180~220	250~290
V-up,OH	100~140	120~160	-