SFA 309L(P)

Stainless steel wires (Fcaw)

Description

SFA 309L(P) is flux cored wire and designed for Fillet & H-F(All-position) welding with CO2 gas Shielding.
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.
Is containing Ferrite of a reasonable quantity and crack-resistance, integranular corrosion resistance, mechanical properties of weld metal is superior.
Shield gas is 100%CO2 or Ar+CO2 gas.
For 22%Cr-12%Ni Stainless Steel.

Notes on usage

The optimum flow of CO2 for Shielding is 20~25ℓ/min.

Protect the weld with a screen to prevent blowholes caused by wind where the wind velocity is 2 m/sec and more.

Keep the distance between tip & base metal at 15~25mm.

Applications

SFA 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 cladded side groove cladded stainless steel or carbon steel where stainless steel weld metal is overlayed.

Classification

AWS A5.22 E309LT0(1)-1/-4	KS D 3612 YF309LC	JIS Z3323 TS309L-FB0(1)

Typical weld metal chemical composition (%) (Shielding Gas : 100%CO2)

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

All weld metal mecanical properties (typical) (Shielding Gas : 100%CO2)

	Yield Strength N/mm2(MPa)	Tensile Strength N/mm2(MPa)	EL (%)	IV (J)
				0°C
SFA 309L	424	580	39.0	48
SFA 309LP	427	585	38.0	50

Size & recommended current range (DC+)

Dia. mm (in)	Current (A)	Voltage (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