



E309LT1-1/4

DESCRIPTION: E309LT1-1/4 is suitable for welding of 22%Cr-12%Ni steel (SUS 309S), 18% Cr-8%Ni clad steel and dissimilar materials such as Cr-Mo steel or mild steel to stainless and build-up welding of carbon steel. E309LT1-1/4 is a flux cored wire for Flat, H-Fillet, V-up, down position welding for CO₂ or Ar-CO₂ (75%Ar-25%CO₂) shielding gas. It provides excellent usability with stable arc, less spattering, good bead appearance. For mechanized welding of H-Fillet this wire is an excellent choice, as it meets the requirement of superior wire feeding properties combined with high deposition efficiency.

APPROVAL: CWB(A5.22 E309LT1-1/4) & AWS A5.22 E309LT1-1/4

CHEMICAL COMPOSITION

CARBON	.028
SILICON	.60
MANGANESE	1.61
PHOSPHORUS	.012
SULFUR	.010
NICKEL	10.10
CHROMIUM	19.42

MECHANICAL PROPERTIES

Tensile Strength	
85,000 PSI	590 MPA
Yield Strength	
76,000 PSI	527 MPA
Elongation	
42%	

DEPOSITION WELDING

WELDING PROCEDURE

Wire diameter: 1.2mm

Amperage: 180~220A

Voltage: 30~32V

Current & polarity: DCEP

Shielding gas: CO₂100%, 20ℓ/min

Wire Stick-out: 20~ 25mm

Interpass temp: 150°C max.

Welding position: Flat

Welding speed: 300~400mm/min

Preheat temp: N/A

Root treatment: No

BUTT WELDING

WELDING PROCEDURE

Wire diameter: 1.2mm

Amperage: 180~220A

Voltage: 30~32V

Current & polarity: DCEP

Shielding gas: CO₂100%, 20ℓ/min

Wire Stick-out: 20 ~ 25mm

Interpass temp.: 150°C max.

Welding position: Flat

Welding speed: 300~ 400mm/min

Preheat temp: N/A

Root Treatment: No

Weldcote Metals believes this data to be accurate and to reflect qualified expert opinion regarding current research. However, Weldcote Metals can not make any expressed or implied warranty as to this information.