

## MIG/MAG Cored Wires Stainless and Heat resistant steels

FLUXINOX 309L is an alloyed rutile flux cored wire for joining high-alloyed Cr and Cr-Ni-(Mo) steels with unalloyed steels, as well as for depositing austenitic stainless cladding. The highest operating temperature for dissimilar joints is 300°C. The weld metal is non-scaling up to 850°C. Preheating and interpass temperatures should be calculated according to the base metal used.

FLUXINOX 309 L exhibits outstanding, almost spatter-free, welding properties. It produces finely rippled flat and smooth welds, free of undercut into the base metal. Very easy slag removal.

Classification	
EN ISO	17633-A: T 23 12 L R C 3
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EN ISO	17633-B: TS309L-FB0
AWS	A5.22: E309LT0-1
AWS	A5.22: E309LT0-4

Approvals	Grade
DB	●
DNV	309L
GL	4332S
LRS	SS/CMn
TÜV	●

CE

### Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Ferrite
≤ 0.04	1.5	0.6	≤ 0.03	≤ 0.03	24	13	12-20

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation	Impact Energy ISO - V (J)	
				-20 °C	-60 °C
As Welded	≥ 320	≥ 520	≥ 30	≥ 40	≥ 27

Gas test: 82% Ar+18% CO<sub>2</sub>

**Shielding Gas** - EN ISO 14175 : C1, M21

### Materials

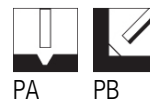
A312 TP309S; Ferrite-Austenite heterogeneous joints, Cladding

#### Storage

Keep dry and avoid condensation

#### Current condition and welding position

DC+



### Packaging data

Packaging Type	BS300
Diam(mm) / weight(kg)	15
1.0	●
1.2	●