

SuperCore™ 309LP

TOP FEATURES

- Easy operability, high deposit quality and exceptional weld bead appearance for downhand and HV welding
- Unparalleled consistency in weldability and mechanical properties

CLASSIFICATION

AWS A5.22	E309LT1-1/4
EN ISO 17633-A	T 23 12 L R C/M 2
EN ISO 17633-B	TS309L-F C1/M21 1

CURRENT TYPE

DC+

SHIELDING GASES (ACC. EN ISO 14175)

M21	Mixed gas Ar+ 15-25% CO ₂
C1	Active gas 100%
Flow rate	20-25 l/min

Proprietary gases may be used but argon should not exceed 85%.

APPROVALS

ABS	DNV	TÜV
+	+	+

CHEMICAL COMPOSITION (WEIGHT %), WELD METAL

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	FN
Min.		0.5				22.0	12.0			12
Max.	0.04	2.0	1.0	0.025	0.030	25.0	14.0	0.3	0.3	22
Typical	0.03	1.3	0.6	0.02	0.02	24	12.5	0.1	0.1	15

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

As welded	Min.	Typical
Tensile strength (MPa)	520	575
0.2% Proof strength (MPa)	320	425
Elongation (%) 4d	30	40
5d	25	39
Reduction of area (%)		52
Impact ISO-V (J) +20°C		42
-20°C		40
Hardness, cap/mid (HV)		205/215

PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.2	SPOOL (S300)	15.0	SC309LP-12

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.