

FLUXINOX 309L PF

TOP FEATURES

- High alloyed rutile flux cored wire with fast freezing slag for the welding of dissimilar joints, buffer layers or cladding.
- FLUXINOX 309L PF exhibits outstanding, almost spatter-free, welding properties with very easy slag removal. Designed for welding in the horizontal (PD), overhead (PE) and vertical-up (PF) positions.
- The best quality of welds with standard CV power sources helps to reduce investment expenditures. Application of standard Ar/CO₂ or CO₂ shielding gases optimizes welding cost.
- High productivity generates savings in total welding costs. Optimal semiautomatic process with high duty cycle.
- Savings in total welding cost resulting from reduced cleaning. Spatter free welds with easy slag removal.
- Higher overall performance and weldability comparing to solid wires and manual stick electrodes.

CLASSIFICATION

AWS A5.22	E309LT1-1 E309LT1-4
EN ISO 17633-A	T 23 12 L P M21 1 T 23 12 L P C1 1
EN ISO 17633-B	TS309L-FB1

CURRENT TYPE

DC+

WELDING POSITIONS

All positions

SHIELDING GASES (ACC. EN ISO 14175)

C1	Active gas 100% CO ₂
M21	Mixed gas Ar+ 15-25% CO ₂

APPROVALS

LR	DNV	RINA	TÜV
+	+	+	+

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Si	Cr	Ni	Ferrite
≤0.04	0.7	0.6	24	13	10-20

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)	
						-20°C	-60°C
Typical values	M21	AW	≥320	≥520	≥30	≥40	≥27

* AW = As welded

Gas test: 82% Ar + 18% CO₂

PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.2	SPOOL (BS300)	15.0	W000281308

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.