FLUXINOX 309L

TOP FEATURES

- Excellent corrosion resistance thanks to low carbon content and balanced chemistry
- High weld quality with standard CV power sources—reducing investment costs
- High productivity leads to lower overall welding costs
- Reduced cleaning time due to spatter-free welds and easy slag removal
- Superior performance and weldability compared to solid wires and stick electrodes

CLASSIFICATION

AWS A5.22	E309LT0-1
	E309LT0-4
EN ISO 17633-A	T 23 12 L R M21 3
	T 23 12 L R C1 3
EN ISO 17633-B	TS 309L-F M21 0
	TS 309L-F C1 0

CURRENT TYPE

DC+

WELDING POSITIONS

Flat/Horizontal

APPROVALS

LR, DNV, TÜV, DB

SHIELDING GASES (ACC. EN ISO 14175)

C1	Active gas 100% CO_2
M21	Mixed gas Ar+ 15-25% CO_2

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

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

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% CO_2

AVAILABLE SIZES AND PACKAGING INFORMATION

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.2	SPOOL (BS300)	15.0	W000281304

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.