CLEAROSTA F 309L

TOP FEATURES

- Advantageous in confined spaces and with limited fume extraction systems.
- It exhibits outstanding, almost spatter-free, welding properties and produces finely rippled flat and smooth welds which are free of undercut.
- Very easy slag removal.
- Due to its fast-freezing slag, it can be used for welding in the horizontal (PD), overhead (PE) and vertical-up (PF) positions.

TYPICAL APPLICATIONS

- Joining high-alloyed Cr and Cr-Ni-(Mo) steels to unalloyed steels.
- Steel construction
- Shipbuilding

CLASSIFICATION

AWS A5.22	E309LT1-1/4
EN ISO 17633-A	T 23 12 L P M 1

CURRENT TYPE

DC+

SHIELDING GASES (ACC. EN ISO 14175)

M21	Mixed gas Ar+ 15-25% CO_2
C1	Active gas 100% CO_2
Gas flow	15-25l/min

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

Shielding gas	C	Mn	Si	Cr	Ni	FN (acc. WRC 1992)
M21/C1	0.04	0.7	0.6	24.0	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	Impact ISO-V (J) -60°C
Typical values	M21/C1	AW	≥320	≥520	≥30	≥40	≥27

* AW = As welded

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.