

# STRONG FCAW E309L

CLASSIFICATION: AWS SFA 5.22 E309LT1-1/4

## STAINLESS STEEL FLUX CORED ARC WELDING WIRE



### CHARACTERISTICS

STRONG FCAW E309L is an all-position, extra low carbon gas shielded flux-cored wire designed for MAG welding of 23%Cr-13%Ni stainless steels. It provides weld deposits with high oxidation resistance up to 1100°C and excellent resistance to cracking and corrosion. This wire provides stable arc, low spatter, easy slag removal, excellent bead appearance and radiographic quality welds.

### APPLICATIONS

STRONG FCAW E309L is an excellent choice for welding of pipes, tubes, castings and vessel components of grade AISI 309L type. This is also a very good choice for joining stainless steel to carbon steel. Typical application in Chemical, Food processing industries, Pipes & tubes, Pressure vessels, tanks used in pulp and paper, textile dyeing and refinery equipment.

### TYPICAL WELD METAL CHEMISTRY (%)

C	Mn	Si	P	S	Cr	Ni	Mo
0.04 MAX	0.50- 2.50	1.00 MAX	0.03 MAX	0.04 MAX	22.0- 25.0	12.0- 14.0	0.50 MAX

### ALL WELD MECHANICAL PROPERTIES

Required as per AWS 5.22	Y.S. MPa	U.T.S. MPa	ELONGATION %
Typical Results As Welded	415	620	34

### PACKAGING SPECIFICATIONS - FCAW

DIA SIZE 1.20MM / 1.60MM

SPOOL WEIGHT 12.5KGS