

Cor-A-Rosta® 309L

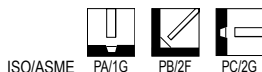
CLASSIFICATION

AWS A5.22 : E309LT0-1/-4
 ISO 17663-A : T 23 12 L R C/M 3

GENERAL DESCRIPTION

Gas shielded flux cored high CrNi alloyed wire electrode for downhand welding
 For welding stainless to mild steel and buffer layers in clad steel
 Excellent weldability and self releasing slag
 High resistance to embrittlement

WELDING POSITIONS



CURRENT TYPE

DC +
 M21 : Mixed gas Ar+ (>15-25%) CO₂
 C1 : Active gas 100% CO₂
 Amount : 15-25 l/min

APPROVALS

Shielding gas	BV	DNV	GL	LR	TÜV
M21		308LMS	4550S		+
C1	309L	309LMS		SS/CMn	pending

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

Shielding gas	C	Mn	Si	Cr	Ni	FN (acc.WRC 192)
M21 / C1	0.03	1.4	0.6	24	12.5	15

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J)	
						+20°C	-20°C
Required: AWS A5.22 ISO 17663-A Typical values	M21/C1	AW	not required min. 320 445	min. 520 min. 510 560	min. 30 min. 25 36	45	40

PACKAGING AND AVAILABLE SIZES

Diameter (mm)	1.2	1.6
Unit : 5 kg plastic spool S200	X	X
15 kg spool S300	X	

Cor-A-Rosta® 309L - rev. EN 25

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MATERIALS TO BE WELDED

Steel grades	EN 10088-1/-2	Mat. Nr	ASTM/ACI A240/A312/A351	UNS
Corrosion resistant cladsteels				
	X2 CrNiN 18-10	1.4311	(TP)304LN	S30453
	X2 CrNi 19-11	1.4306	(TP)304L	S30403
			CF-3	J92500
	X4 CrNi 18-10	1.4301	(TP)304	S30400

Dissimilar metals (mild and low alloyed steel to CrNi or CrNiMo stainless steel)

Build-up welding on mild and low alloyed steel

WELDING PARAMETERS, OPTIMUM FILL PASSES

Diameter (mm)	Welding positions		
	PA/1G	PB/2F	PC/G
1.2	100-250A	100-250A	100-200A
1.6	140-300A	140-300A	140-200A

REMARKS/APPLICATION ADVICE

For positional welding, use Cor-A-Rosta P309L