

# Cor-A-Rosta® P309L

## CLASSIFICATION

AWS A5.22	E309LT1-1/-4	A-Nr	8	Mat-Nr	1.4332
ISO 17633-A	T 23 12 L P C/M 2	F-Nr	6		
		9606 FM	5		

## GENERAL DESCRIPTION

Gas shielded flux cored high CrNi alloyed wire electrode for positional 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 (ISO/ASME)



## CURRENT TYPE / SHIELDING GAS (ISO 14175)

DC +  
 M21 : Mixed gas Ar+ (>15-25%) CO<sub>2</sub>  
 C1 : Active gas 100% CO<sub>2</sub>  
 Flow rate: 15-25 l/min

## APPROVALS

Shielding gas	ABS	DNV	LRS	TÜV
M21	+	+	+	+
C1	+	+	+	

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

Shielding gas	C	Mn	Si	Cr	Ni	FN (acc.WRC 1992)
M21 /C1	0.04	1.3	0.6	24	12.5	15

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition	Yield strength [N/mm <sup>2</sup> ]	Tensile strength [N/mm <sup>2</sup> ]	Elongation [%]	Impact ISO-V(J)	
						+20°C	-20°C
Required: AWS A5.22 ISO 17633-A			not required min. 320	min. 520 min. 510	min. 30 min. 25		
Typical values	M21/C1	AW	445	560	36	45	40

## PACKAGING AND AVAILABLE SIZES

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

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All information in this data sheet is accurate to the best of our knowledge at the time of printing. Please refer to [www.lincolnelectric.eu](http://www.lincolnelectric.eu) for any updated information.  
 Fumes: Material Safety Data Sheets (MSDS) are available on our website.

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## EXAMPLES OF MATERIALS TO BE WELDED

Steel grades	EN 10088-1/-2	Mat. Nr	ASTM/ACI A240/A312/A351	UNS
<b>Corrosion resistant cladsteels</b>				
	X2CrNiN18-10	1.4311	(TP)304LN	S30453
	X2CrNi19-11	1.4306	(TP)304L	S30403
			CF-3	J92500
	X4CrNi18-10	1.4301	(TP)304	S30400

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

## WELDING PARAMETERS, OPTIMUM FILL PASSES

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

## REMARKS/APPLICATION ADVICE

For downhand welding, use Cor-A-Rosta 309L

FCAW