

SW-309LNS Cored

Type : Metal-Cored

Conformances

AWS A5.9/ ASME SFA5.9 EC309L
 JIS Z3323 TS309L-MA0
 EN ISO 17633-A-T 23 12 L M M21/I1

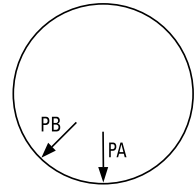
Applications

- Automotive mufflers
- Welding of dissimilar metals such as stainless and carbon a low alloy steels

Features

- Non-slag type
- Low spatter

Welding Position



Current

DC +

Shielding Gas

Ar + 2% O₂

Diameter / Packaging

Diameter mm (in)	Spool			Pac		
	5kg (11lbs)	12.5kg (27.6lbs)	15kg (33lbs)	250kg (551lbs)	300kg (661lbs)	350kg (771lbs)
1.2 (0.045)		✓	✓	✓	✓	✓
1.6 (1/16)		✓	✓	✓	✓	✓

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Ni	Mo	Cu
0.025	0.5	1.8	0.02	0.01	24.0	13.0	0.13	0.12

Typical Mechanical Properties of All-Weld Metal

TS MPa(lbs/in ²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft-lbs)
590 (85,600)	45	-20 (-4)	60 (44)

Typical Welding Parameters

Diameter, Polarity Shielding Gas	CTWD mm (in)	Wire Feed Speed m/min (in/min)	Amp. (A)	Volt. (V)	Deposition Rate kg/hr (lb/hr)
1.2mm (0.045 in) DC+					
Ar + 2% O ₂	20 (0.78)	5.5 (216)	190	23~25	4.2 (9.1)
		6.6 (260)	220	25~27	5 (10.9)
		8.1 (320)	250	26~28	6 (13.0)