

FCW

Filler FCW-309LP

for Stainless Steel Flux Cored Wire

CLASSIFICATIONS: AWS A5.22 : E309LT1-1
 EN ISO 17633-A : T 23 12 L P C1
 EN ISO 17633-B : TS 309L-F C1 1
 JIS Z 3323 : TS309L-FC1

WELDING POSITIONS :



DESCRIPTION AND APPLICATIONS

Filler FCW-309LP is designed for 100% CO₂ gas shielding and all position welding. It performs with smooth arc transfer, low spatter level, fine ripple, fast freezing slag, easy control of weld pool and good hot crack resistance.

Commonly used for welding dissimilar metals such as 304 to mild and carbon steels, low alloy steels, heat resistance steels and clad steels.

TYPICAL ALL WELD METAL COMPOSITION (Wt%)

C	Mn	Si	Cr	Ni	Mo	Cu	S	P
0.03	1.35	0.53	23.80	12.80	0.04	0.03	0.011	0.010

- Shielding Gas: 100% CO₂

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES

YIELD STRESS	TENSILE STRENGTH	ELONGATION	CHARPY IMPACT VALUES
435 MPa	570 MPa	39%	45J @ -30°C

SIZES AND RECOMMENDED CURRENT RANGE (DC+)

DIAMETER Φ (mm)	VOLTAGE (V)	CURRENT (A)	SPOOL (KG)
0.8	17 - 25	50 - 140	5
1.0	19 - 31	70 - 170	12.5
1.2	22 - 36	120 - 220	12.5
1.6	26 - 38	200 - 300	12.5

- Use DC+ polarity and CO₂ as shielding gas.
- Gas flow rate 20 - 25 l/mm.