K-309T

Austenitic Stainless welding wire (Dissimilar joints)

Classifications

EN ISO 17633-B:2008	: TS309-FB0	KS D 3612	: YF-309C
AWS A5.22-15	: E309T0-1/4	JIS Z 3323	: TS309-FB0

Description

- K-309T is formulated for MAG welding of 22%Cr-12%Ni stainless steels and typical applications is for welding of dissimilar steels, such as 304 to mild steel or low alloy steels.
- K-309T is a titania type of flux cored wire for cladding and dissimilar joint welds.
- Weld metals contain comparatively much more ferrite in their austenitic, therefore they provide better weldability together with superior heat resistance, and corrosion resistance.
- It is designed for operation in the flat position and for wedling horizontal fillet welds.

Welding positions

Polarity & shielding gas

- CO_2: 100% CO_2,
  Mix: Ar+20% CO_2 (15~25ℓ/min)
- DCEP (DC+)

Typical chemical composition of all-weld metal (%)

Shielding gas	C	Si	Mn	Cr	Ni	FN
CO_2	0.05	0.58	1.45	23.50	13.00	14
Mix	0.05	0.70	1.63	23.70	13.20	15

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J) -40℃	Remarks
AWS A5.22		min. 550	min. 30		
EN ISO 17633-B		min. 550	min. 25		
Example	450	590	35	40	CO_2
	460	610	34	44	Mix

Notes on usage and welding condition

- Refer to page 303 for more information on usage
- When heat input is excessive, base metal will be bended or distorted due to the bad heat conductivity. Therefore, perform welding with selecting proper heat input

Package

Dia. (mm)	0.9	1.2	1.6
Spool (kg)		5, 12.5, 15	