

## Flux Cored Welding Wire

# K-309MoLT

Austenitic Stainless welding wire (Dissimilar joints)

### Classifications

EN ISO 17633-A:2010	: T 23 12 2 L P C1 1	KS D 3612-2016	: YF-309MoLC
EN ISO 17633-B:2010	: TS 309LMo-F C1 1	JIS Z 3323-2007	: TS309LMo-FC1
AWS A5.22-2012	: E309LMoT1-1		

### Description

- Dissimilar joint welds ; of and between high-strength, mild steels and low-alloyed QT-steels, stainless, ferritic Cr- and austenitic Cr-Ni-steels, manganese steels.
- Cladding ; for the first layer of corrosion resistant weld claddings on ferritic-perlitic steels in boiler and pressure vessel parts up to fine-grained steel S500N.
- Wire is a titania type of flux cored wire for all-position welding and for Mo-alloyed claddings the product is necessary for the 1st layer.
- Weld metals contain comparatively much more ferrite in their austenitic, therefore they provide better weldability together with superior heat resistance, and corrosion resistance.

### Welding positions



### Polarity & shielding gas

- CO<sub>2</sub>: 100% CO<sub>2</sub> (15~25ℓ/min)
- DCEP (DC+)

### Typical chemical composition of all-weld metal (%)

Shielding gas	C	Si	Mn	Cr	Ni	Mo	FN
CO <sub>2</sub>	0.03	0.60	1.00	23.75	14.60	2.50	18.0

### Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	EI. (%)	IV (J) -30°C	Remarks
AWS A5.22		min. 520	min. 25		
EN ISO 17633-B	min. 350	min. 550	min. 25		
Example	480	700	30	35	CO <sub>2</sub>

### Notes on usage and welding condition

- Refer to page 313 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)	1.2	1.6
Spool (kg)	5, 12.5, 15	

### Approvals

ABS, KR, JIS

\* Please refer to our homepage([www.kiswel.com](http://www.kiswel.com)) for further detailed information regarding approvals.