Cor-Revicod® 309LT0

Stainless rutile cored wire

Classification

AWS A5.22	:E 309LT0-1/-4
ISO 17663	:T 23 12 L R C/M 3

General description

Gas shielded flux cored high CrNi alloyed wire for downhand welding
For welding stainless to mild steel and buffer layers in clad steel
Excellent weldability and slag release
High resistance to embrittlement

Welding positions

ISO/ASME	PA/1G	PB/2F	PC/2G

Current type / Shielding gases

DC +
Ar+(>5-25)% CO_2 (EN 439:M21)
100% CO_2 (EN439:C1)
15-25 l/min

Approvals

Shielding gases	BV	DNV	GL	LR
M21	309L	309LMS	4332S	SS/CMn
C1	309L	309LMS		SS/CMn

Typical chemical composition of all weld metal, (w%)

Shielding gases	C	Mn	Si	Cr	Ni	FN
M21/C1	0.03	1.4	0.6	24	12.6	15

Mechanical properties of all weld metal

		Shielding gas	Condition	Yield strength (N/mm^2)	Tensile strength (N/mm^2)	Elongation (%)	Impact (ISO), J	
							+20°C	-20°C
Required	AWS A5.22			not required	min 520	min 30		
	ISO 17663			min 320	min 510	min 25		
Typical values after welding		M21/C1	AW	450	580	36		40

Packaging, available sizes and identification

Unit type	Net weight/unit (kg)	Diameter (mm) 1.2	1.6
Wire reel B202	5	X	
Plastic spool S300	12.5	X	X

Identification	Imprint: Cor-Revicod®309LT0

Cor-Revicod®309LT0: rev. EN 20

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Materials to be welded

Steel	EN 10088-11-2	EN 102 13-4	W.Nr.	ASTM/ACI A240/A312/A351	UNS
Corrosion resistant and	X2 CrNiN 18-10		1.4311	(TP)304LN	S30453
Clad steel	X2 CrNi 19-11		1.4306	(TP)304L CF-3	S30403
	X4 CrNi 18-10		1.4301	(TP)304	S30400

Dissimilar metals, mild and low alloyed steel to CrNi or CrNiMo stainless steel
Build-up welding on mild and low alloyed steel

Welding parameters, optimum fill, Shielding gases M21/C1

Diameter (mm)	Current / Voltage	Welding position PA/1G	PB/2F	PC/2G	PF/3G up	PE/4G
1.2		100-250	100-250	100-200		
1.6		140-300	140-300	140-200		

Remarks/ Application advice

Use for positional welding: Cor-Revicod® 309LT1