

RASI E 309L-T1-1

MADE IN INDIA

FLUX CORED WIRE - AWS E 309L-T1-1

CHARACTERISTICS

RASI E 309L-T1-1 is a stainless steel flux core welding wire for all position welding with CO₂ gas shielding. It gives 23% Cr and 12% Ni weld deposit with excellent all around performance and resistance to chemical corrosion. Weld metal is of radiographic quality with easy slag removal very and low spatters.

WELDING POSITIONS

F, H, V-up and OH

CLASSIFICATIONS

AWS A / SFA 5.22 E309LT1-1

TYPICAL APPLICATIONS

suitable for the welding of dissimilar metals such as stainless steel and carbon steel or stainless steel and low alloy steel

SHIELDING GAS

Carbon Dioxide (CO₂) shielding
Gas Flow :15-20 Lit / Min
Current Condition : DC (+)

Chemical Composition of Wled Metal (wt %)

	C %	Mn %	Si %	S %	P %	Cr %	Ni %	Mo %	Cu %
Typical Results	0.040	0.5-2.50	0.010 Max	0.030 Max	0.040 Max	22-25	12-14	0.50 Max	0.50 Max

All Weld Metal Mechanical Properties :-

	UTS (mpa)	YS (mpa)	Elongation % (L=4xd)	CVN impact at -30C
Typical Results	520 min	---	30 min	---

Welding Parameters (DC + VE)

Diameter	Amps	Volts
1.20 mm	120 - 210	22 - 30
1.60 mm	160 - 250	22 - 30

*FOR APPROVALS AND CERTIFICATIONS KINDLY CONTACT :- info@rasielectrodes.com

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