

## Exaton 309/309L T1

FCAW wire for 22%Cr - 12%Ni stainless steel, For all-position welding. Designed for welding type 309 wrought or cast forms, but used extensively for welding type 304 to mild or carbon steel. Also used for welding 304 clad sheets and for applying stainless steel sheet linings to carbon steel. Carbon content 0.04% maximum.

Specifications	
<b>Classifications</b>	SFA/AWS A5.22 : E309LT1-1 SFA/AWS A5.22 : E309LT1-4 JIS Z 3323 : YF-309LC KS D 3612 : YF-309LC EN ISO 17633-A : T 23 12 L P C1 2 EN ISO 17633-A : T 23 12 L P M21 2

<b>Welding Current</b>	DC+
<b>Alloy Type</b>	C Cr Ni

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
<b>M21 Shielding Gas</b>			
As Welded	480 MPa ( 70 ksi )	600 MPa ( 87 ksi )	35 %
<b>C1 Shielding gas</b>			
As Welded	392 MPa ( 57 ksi )	539 MPa ( 78 ksi )	51 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
<b>C1 Shielding gas</b>		
As Welded	-196 °C ( -321 °F )	18 J ( 13 ft-lb )
As Welded	-29 °C ( -20 °F )	55 J ( 41 ft-lb )

Typical Weld Metal Analysis %							
C	Mn	Si	S	P	Ni	Cr	
<b>M21 Shielding Gas</b>							
0.030	1.30	0.90	0.007	0.024	12.5	23.5	
<b>C1 Shielding gas</b>							
0.030	1.30	0.90	0.007	0.024	12.5	23.5	

Deposition Data				
Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.2 mm ( 0.045 in. )	130-220 A	24-29 V	5.8-14.4 mm/min ( 228-567 in./min )	1.9-4.6 kg/h ( 4.2-10. lbs/h )