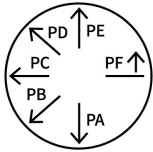


SW-309L Cored

Classification

AWS AWS A5.22/ ASME SFA-5.22 E309LT1-1/-4
JIS Z 3323 TS309L-FB1
EN ISO 17633-A-T 23 12 L P M21/C1 2

Welding Positions



Features

- Good performance in all positions

Polarity

DC+

Application Areas

- 23.5%Cr-13%Ni stainless steel
- Dissimilar welds between carbon, low alloy steels to stainless steels
- Buffer layer welding for cladding, overlays

Shielding Gas

100% CO2
Ar+20~25% CO2

Approvals

ABS	BV	CCS	CRS	DNV	KR	LR	NK	RINA	RS	CWB	CE	DB	TUV
✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓

Typical Chemical Composition of All-Weld Metal (wt%)

Shielding Gas	C	Si	Mn	P	S	Cu	Ni	Cr	Mo
100% CO2	0.03	0.7	1.3	0.021	0.006	0.13	12.9	23.4	0.13
Ar+20~25% CO2	0.03	0.8	1.4	0.021	0.006	0.12	12.8	23.5	0.13

Typical Mechanical Properties of All-Weld Metal

Shielding Gas	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft·lbs)
100% CO2	540(78)	41	-20(0) -60(-75)	49(36) 46(34)
Ar+20~25% CO2	555(80)	37	-20(0) -60(-75)	46(34) 40(30)

Diameter / Welding Parameters / Packaging

Wire Diameter mm(in)	Current (A)	Packaging
1.2 (0.045)	160~220	Spool 5kg(11lbs), 12.5(27.6lbs), 15kg(33lbs)
1.6 (1/16)	250~290	

SMW

GMW

GTW

FCW

Metal-cored Wire

SAW Wire

SAW Flux