

Flux Cored Wire for Stainless Steel

Classification

KFW-309LF

AWS	A5.22	E309LT0-1/4
JIS	Z3321	TS308L-FB0
EN	17633-A	T 23 12 L R C1/M3
GB	T 17853	E308LT0-1/4

Shielding Gas: CO₂ or Ar+20%CO₂

Applications and Features

- (1) Weld metal is 23.5%Cr-13%Ni.
- (2) It is suitable for joining stainless steel to carbon steel or low alloy steel.
- (3) It provides excellent weldability, corrosion resistant and crack resistance due to proper ferrite contents in the weld metal.
- (4) It provides stable arc, good slag removal, and easy control of weld puddle, low spatters and good penetration.
- (5) It has bright silvery bead appearance and good wettability.

Welding Position

F (IG), H-Fillet (2F)

Welding Instruction

- (1) For welding dissimilar metals, please refer to Appendix I.
- (2) For other instructions, please refer to Appendix D.
- (3) For extra information, please refer to Appendix F.

Typical Chemical Composition of Weld Metal (wt %) (Shielding Gas : CO₂)

C	Si	Mn	P	S	Cr	Ni
0.035	0.53	1.14	0.020	0.004	24.01	12.16

Typical Mechanical Properties of Weld Metal (Shielding Gas : CO₂)

Tensile Strength N/mm ² (kgf/mm ²)	Elongation %
515(52.55)	38

Size and Suggested Operating Range (DC+)

Diameter (mm)	F/H-fillet		V/OH	
	Amp	Volt	Amp	Volt
1.2	100~300	20~36	100~200	24~30
1.6	200~360	26~40	—	—