



# Cromacore 309LT0

FCAW - Flux cored arc welding  
Stainless Steel

Date: 2016-05-25  
Revision: 2

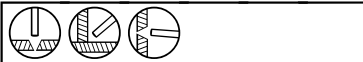
## Description:

Cromacore 309LT0 is a rutile flux cored wire which deposits a low carbon 24% Cr / 13% Ni stainless steel weld metal with a ferrite content of about FN 14. The wire operates with a very stable, spatter free arc producing a bright, smooth weld bead surface and self-releasing slag. Cromacore 309LT0 is used mainly for horizontal-vertical welding and is ideal for standing fillets.

## Applications:

Dissimilar joints between stainless and mild or low alloy steels.  
Buffer layers on mild and low alloy steels prior to overlaying with Cromacore 308 or 347.  
Interface runs on clad steel joints.  
Welding of similar composition, 309 type, stainless steels.  
Joining of ferritic-martensitic stainless steels.

## Welding positions:



## Welding current:

DC+

## Deposition efficiency:

87%

## Shielding gas:

M21, 80% Ar + 20% CO<sub>2</sub>, 22-25 l/min

## Stick-out:

15-20 mm

## Ferrite content:

FN 12

## Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min			0,5			22,0	12,0
Typical	0,026	0,66	1,51	0,025	0,009	23,80	13,20
Max	0,04	1,0	2,5	0,030	0,025	25,0	14,0

	Mo	Cu
Min		
Typical	0,07	0,13
Max	0,30	0,50

## Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Rp0.2%:		428 MPa
Tensile Strength, Rm:	≥ 520 MPa	568 MPa
Elongation, A5	≥ 30%	34%
Impact energy, CV:		-20 °C • 37 J

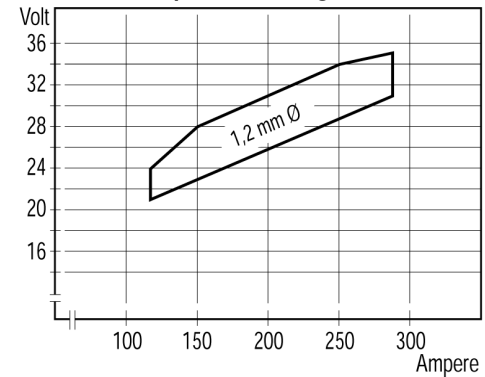
## Classification:

EN ISO 17633-A T 23 12 L R M 3  
AWS A5.22 E309LT0-4

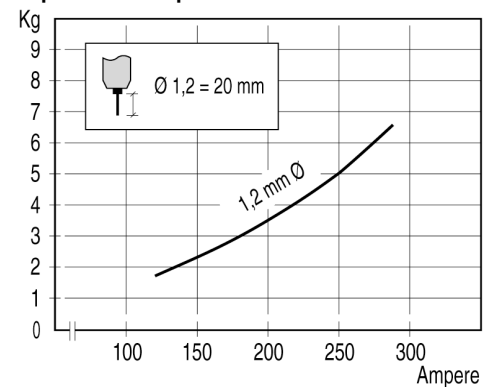
## Approvals:

CE  
TÜV

## Recommended parameter range:



## Deposition rate per hour:



## Product data:

Diam.mm	Product code	Spool weight
1,2	94721012	15 kg BS300
1,2	94722112	5 kg D200