



PRIME 309LP

Stainless Steel Flux Cored Wire

CLASSIFICATIONS: AWS A5.22: E309LT1-1
 EN ISO 17633-A: T 23 12 L P C1 1
 EN ISO 17633-B: TS 309L-F C1 1
 JIS Z3323: TS 309L-FC1

Purpose: Used for dissimilar welding of carbon steel and stainless steel, as well as components of the same type of stainless-steel structures, composite steel and dissimilar steel used in equipment manufacturing such as petrochemical industry. It can also be used for welding on transition layer of inner wall of nuclear reactor pressure vessels and tower internal components.

Introduction: The rutile type stainless steel flux cored welding wire and can be welded in all position. The welding process has excellent performance and mechanical properties. Due to its low carbon content, it has excellent crack resistance and corrosion resistance.

Chemical Composition (%)									
Item	C	Mn	Si	S	P	Ni	Cr	Mo	Cu
Standard	≤0.04	0.5-2.5	≤1.0	≤0.03	≤0.04	12.0-14.0	22.0-25.0	≤0.75	≤0.75
Example Value	0.021	1.37	0.62	0.012	0.018	12.78	23.56	0.08	0.028

Deposited Metal Mechanical Properties (%)		
Test Item	Rm/MPa	A%
Standard	≥520	≥25
Example Value	583	34

Reference specification: DC				
Size (mm)		1.0	1.2	1.6
Current (A)	Flat Welding	100-180	160-240	180-280
	Vertical Welding	90-160	120-180	120-220
	Horizontal Welding	100-180	140-220	160-260

WELDING POSITIONS: