

MAXFIL-309L

Stainless Steel Flux Cored Wire

CODIFICATION: AWS/SFA 5.22
E309LT1-1

CHARACTERISTICS AND APPLICATIONS:

Maxfil-309L is an all position stainless steel flux cored wire to deposit good oxidation resistance (up to 1100°C) weld metal with radiographic quality. The wire have smooth and stable arc with good slag detachability.

Maxfil-309L is suitable for joining of dissimilar steels like 304 type stainless steels to mild steel & low alloy steel, cladding & overlaying applications, joining of ferritic steels & difficult to weld steels, etc.

CHEMICAL COMPOSITION OF ALL WELD METAL (%):

ELEMENTS	C	Mn	Si	S	P	Cr	Ni	Mo	Cu
RANGE	0.10	0.5-2.5	1.00	0.030	0.040	22.0-25.0	12.0-14.0	0.75	0.75
TYPICAL	0.028	1.40	0.60	0.010	0.020	23.5	12.4	0.020	0.060

MECHANICAL PROPERTIES OF ALL WELD METAL:

Property	UTS (Mpa)	%El (L=4d)
Range	520 Min	30 Min
As Welded	570	38

WELDING POSITIONS: H, F, VU, OH

WELDING PARAMETER: DC (+)

Diameter (mm)	HORIZONTAL/FLAT		VERTICAL UP		OVER HEAD	
	Volt, V	Current, A	Volt, V	Current, A	Volt, V	Current, A
1.20	24-30	160-260	20-22	100-160	22-25	100-160
1.60	24-30	180-300	20-22	110-200	22-25	110-200

SHIELDING GAS: Carbon Dioxide CO₂ (100%) at flow rate 12-15 litres per minute.

PACKING :

Standard size : 1.20 & 1.60mm.

Quantity : Supplied approximately 12.5/15Kgs in a plastic spool. Each spool is sealed in an air tight polythene bag and then packed in a corrugated box.

AUTHORISED DISTRIBUTOR - SALES & SERVICE

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