

# Stainless Steel Flux Cored Wire

## GMX309L

AWS A5.22 E309LT1-1/4  
A5.22M E309LT1-1/4  
JIS Z 3323 TS309L-FB1  
ISO 17633-A-T 23 12 L P C1 1,M21 1

### Product Features:

- Rutile type gas shield flux cored arc welding wire, austenite structure weld metal.
- Low spatter loss and easy slag removal.
- High welding performance, austenite weld metal contains adequate ferrite numbers to get good crack resistance.
- Low carbon content in weld metal to get good inter-granular corrosion resistance.
- Smooth fillet weld size.

### Applications:

- Welding of SUS 309L stainless steel.
- Welding of carbon steels or other high hardening alloy steels to stainless steels (low carbon).
- Cladding or welding of stainless steels to carbon steels or low alloy steels.

Typical chemical composition of all-weld metal (wt%)

C	Si	Mn	Ni	Cr	Fe
0.03	0.64	1.7	13.08	23.68	Bal.

Typical mechanical properties of all weld metal

Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation %	Impact value (-20°C) J
462	574	34	80

Size (mm) & recommended welding parameters

Diameter		1.2mm	1.6mm
Polarity		DC+	DC+
Ampere (A)	Flat / Horizontal position	160~250	200~300
	Vertical / overhead position	100~140	----
Shielding Gas		CO <sub>2</sub> / 80%Ar+20%CO <sub>2</sub>	CO <sub>2</sub> / 80%Ar+20%CO <sub>2</sub>

### Note:

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