

Stainless Steel Flux Cored Wire

GMX309LF

AWS A5.22 E309LT0-1/4
A5.22M E309LT0-1/4
JIS Z 3323 TS309L-FB0
ISO 17633-A-T 23 12 LP C1 3, M21 3

Product Features:

- GMX309LF is a flux cored wire of Rutile system. The smooth weld metal transfer and easy slag removal eliminates unnecessary clean up. The weld bead is uniform, flat to slightly concave and free from porosity.
- Penetration is complete and easy to obtain the flat equal weld leg.
- For welding types of 301, 302, 304, 304L, 305, 308L, 309S steel. The content of lower carbon helps minimize carbide precipitation and obtain more resistance to inter-granular corrosion.

Guideline in Usage :

- Use general CO₂ welding machine, but loosen the wire-feeding roller.
- This wire is formulated for using 75% Argon plus 25% CO₂ gas shielded or straight CO₂ gas. However, the 75%Ar / 25%CO₂ mixture gas will produce a smoother arc with less spatter and slight higher yield and tensile strength.

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

C	Si	Mn	Ni	Cr	Fe
0.03	0.70	1.99	12.77	24.5	Bal.

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %
471	594	32

Size (mm) & recommended welding parameters

Diameter		1.2mm	1.6mm
Polarity		DC+	DC+
Ampere (A)	Flat position	160~220	220~300
	Vertical up position		
Shielding Gas		CO ₂ /80%Ar+20%CO ₂	CO ₂ /80%Ar+20%CO ₂

Note:

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