

Stainless Steel Flux Cored Wire

GMX309L-O

AWS A5.22 E309LT0-3
A5.22M E309LT0-3
JIS Z 3323 TS309L-FN0

Product Features:

- Self shield type flux cored arc welding wire.
- Smooth arc, low spatter loss and easy slag removal.
- Smooth and Good bead appearance, shallow penetration suitable for cladding or buildup.

Applications:

- Welding of SUS 309L stainless steel and dissimilar metal welding of carbon steels to stainless steels.
- Dissimilar metal welding of high hardening alloy steels to stainless steels.
- 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
0.04	0.28	1.78	12.84	24.20	Bal.

Typical mechanical properties of all weld metal

Tensile Strength N/mm ²	Elongation %
604	32

Size (mm) & recommended welding parameters

Diameter	1.2mm	1.6mm	2.4mm
Polarity	DC+	DC+	DC+
Ampere (A)	160~250	200~300	250~450
wire extension (mm)	15~30	20~30	25~35
Shielding Gas	Self Shield	Self Shield	Self Shield

Note:

- Use general CO2 welding machine with proper feed roller pressure.

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