

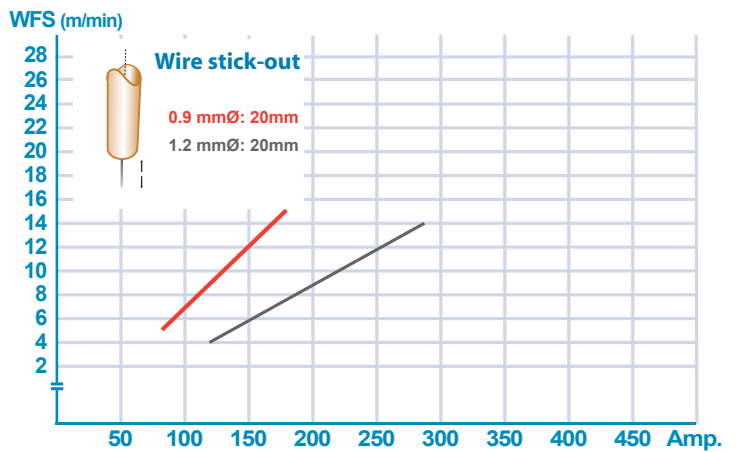
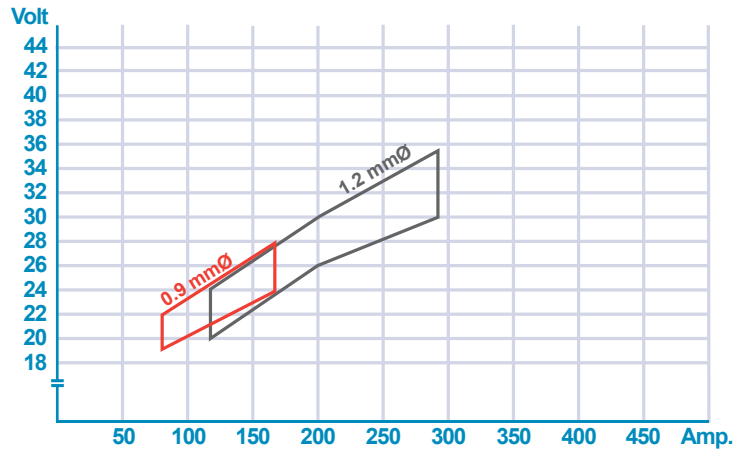
80%Ar - 20%CO<sub>2</sub> / 100%CO<sub>2</sub>  
 EN ISO 17633-A T 23 12 L P C/M 1  
 AWS A5.22 309LT1-1/-4  
 EN 1.4332

## Description and Application

This is a rutile flux cored wire which operates with very stable, spatter free arc producing bright, smooth weld bead surfaces and self releasing slag.

This wire deposit low carbon weld of about 24%Cr-13%Ni. It is designed for dissimilar welding such as welding stainless steel to mild steel or low alloy steel. The wire is also suitable for the first layer on mild or low alloy steel prior to overlaying with PREMIARC™ DW-308L or PREMIARC™ DW-308LP.

## Recommended Parameter Range, for flat position\*



## Typical Chemical Analysis (wt. %)\*

C	Si	Mn	P	S	Ni	Cr	Mo	N	Nb	FS	FN	FNW
0.02	0.42	0.80	0.017	0.005	12.6	23.2	-	-	-	11.7	17.0	14.7

## Typical Mechanical Properties\*

	R <sub>e</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	CV (J) -20°C
	410	580	41	50
Guarantee	min.320	min.520	min.25	

\* The above values and parameters are for all weld metal produced using Ar+CO<sub>2</sub> shielding gas

## Welding Positions



## Approvals

LR	DNV	BV	GL	ABS	R.M.R.S	Others
SS/CMn	309L	309L	4332S	E309LT1-1/4	A-93P	CWB,DB,TÜV

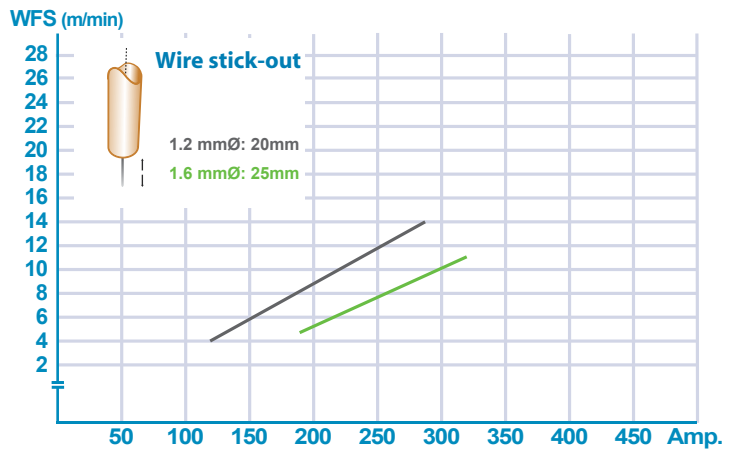
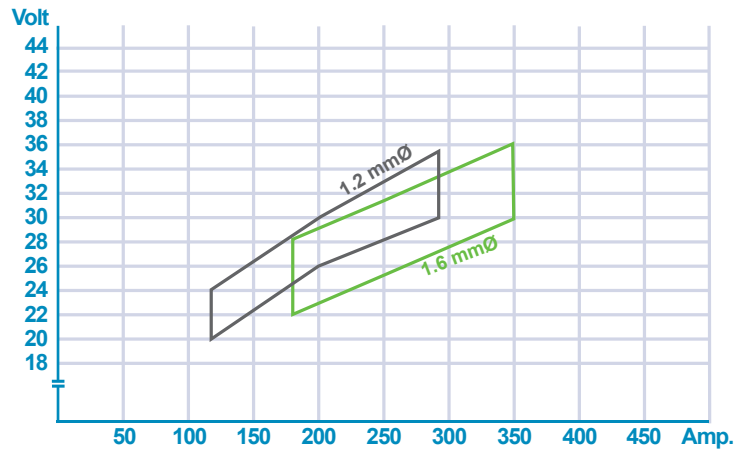
80%Ar - 20%CO<sub>2</sub> / 100%CO<sub>2</sub>  
 EN ISO 17633-A T 23 12 2 L R C/M 3  
 AWS A5.22 E309LMoT0-1/-4  
 EN 1.4459

## Description and Application

This is a rutile flux cored wire which operates with very stable, spatter free arcs producing bright, smooth weld bead surfaces and self releasing slag.

This wire deposits low carbon weld metal of about 23%Cr-13%Ni-2.3%Mo and is designed for dissimilar welding such as welding stainless steel to mild or low alloy steel. This wire is also suitable for the first layer welding on mild steel or low alloy steel prior to overlaying with PREMIARC™ DW-316L/LP or PREMIARC™ DW-317L.

## Recommended Parameter Range, for flat position\*



## Typical Chemical Analysis (wt. %)\*

C	Si	Mn	P	S	Ni	Cr	Mo	N	Nb	FS	FN	FNW
0.02	0.70	1.40	0.018	0.007	12.7	23.2	2.3	-	-	16.8	>18.0	27.0

## Typical Mechanical Properties\*

	R <sub>e</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	CV (J)-20°C
Guarantee	min.350	min.550	min.25	42

\* The above values and parameters are for all weld metal produced using Ar+CO<sub>2</sub> shielding gas

## Welding Positions



## Approvals

LR	DNV	BV	GL	ABS	R.M.R.S	Others
ss/cmn	309MoL	309MoL	4459S	-	-	TÜV,DB