



GB/T 17853 E309LT1-1
AWS A5.22 E309LT1-1
EN ISO17633-A:T 23 12 L P C/M2

AK E309LT1-1

Description: E309LT1-1 is a rutile type stainless steel flux-cored wire, which can be welded in all positions. It has excellent welding process performance and excellent mechanical properties. Due to its low carbon content, it has excellent crack resistance and good corrosion resistance.

Application: It is often used for the same type of stainless steel structure, composite steel and dissimilar steel and other components of the same type of carbon steel and stainless steel dissimilar welding, petrochemical and other equipment manufacturing.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	Cr	Mo	Cu
Requirement	0.04	1.00	0.50-2.50	0.03	0.04	12.0-14.0	22.0-25.0	0.75	0.75
Actual Result	0.021	0.59	1.68	0.010	0.018	12.41	23.85	0.08	0.08

Typical Mechanical Properties:

	Tensile Strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact values (J)
Requirement	≥ 520	— —	≥ 30	— —
Actual Result	550	— —	39	— —

Recommended welding parameters:

Diameter/ mm	1.2	1.6		
Welding voltage/V	22-36	26-38	— —	— —
Welding current/A	120-260	200-300	— —	— —