

Exaton E309LT1-4/1

FCAW wire for 22%Cr - 12%Ni stainless steel, For all-position welding. Designed for welding type 309 wrought or cast forms, but used extensively for welding type 304 to mild or carbon steel. Also used for welding 304 clad sheets and for applying stainless steel sheet linings to carbon steel. Carbon content 0.04% maximum.

Specifications

Classifications	SFA/AWS A5.22 : E309LT1-1 SFA/AWS A5.22 : E309LT1-4 JIS Z 3323 : YF-309LC KS D 3612 : YF-309LC EN ISO 17633-A : T 23 12 L P C1 2 EN ISO 17633-A : T 23 12 L P M21 2
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Welding Current	DC+
Alloy Type	C Cr Ni
Shielding Gas	M21, C1 (EN ISO 14175)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
M21 Shielding Gas			
As Welded	480 MPa	600 MPa	35 %
C1 Shielding gas			
As Welded	392 MPa	539 MPa	51 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
C1 Shielding gas		
As Welded	-196 °C	18 J
As Welded	-29 °C	55 J

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr
M21 Shielding Gas						
0.030	1.30	0.90	0.007	0.024	12.5	23.5
C1 Shielding gas						
0.029	1.10	0.80	0.007	0.024	12.4	23.1

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.2 mm	130-220 A	24-29 V	5.8-14.4 m/min	1.9-4.6 kg/h