



Cromacore DW 309LP

FCAW - Flux cored arc welding
Stainless Steel

Date: 2007-05-25
Revision: 12

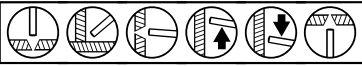
Description:

Cromacore DW 309LP is a fully positional rutile flux cored wire which deposits a low carbon 24% Cr / 13% Ni stainless steel weld metal with a ferrite content of about FN 14. Cromacore DW 309LP operates with a very stable, spatter free arc producing a bright, smooth weld bead surface and self-releasing slag. Ideal for high productivity welding in the vertical position.

Applications:

Dissimilar joints between stainless and mild or low alloy steels.
Buffer layers on mild and low alloy steels prior to overlaying with Cromacore 308L/LP or DW 347.
Interface runs on clad steel joints.
Welding of similar composition, 309 type, stainless steels.
Joining of ferritic-martensitic stainless steels.

Welding positions:



Welding current:

DC+

Deposition efficiency:

87%

Shielding gas:

M21, 80% Ar + 20% CO₂, 22-25 l/min
C1, 100% CO₂, 22-25 l/min

Stick-out:

15-25 mm

Ferrite content:

FN 14

Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min			0.5			22.0	12.0
Typical	0.03	0.7	1.3	0.019	0.010	23.9	12.5
Max	0.04	1.0	2.5	0.030	0.025	25.0	14.0

	Mo	Cu	V	Nb
Min				
Typical	0.1	0.06	0.1	0.08
Max	0.5	0.5	0.2	0.1

Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Rp0.2%:		460 MPa
Tensile Strength, Rm:	≥ 520 MPa	590 MPa
Elongation, A5	≥ 30%	36%
Impact energy, CV:		-20°C • 38 J

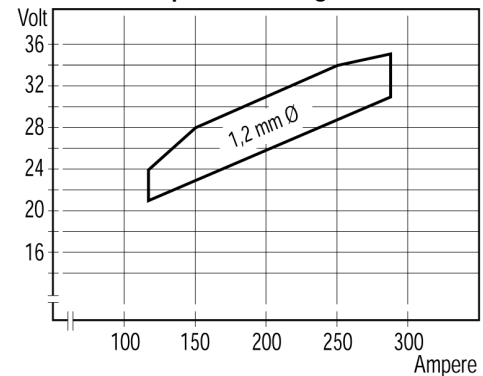
Classification:

AWS A5.22 E 309LT1-4/-1
ISO 17633-A T 23 12 L P M/C 1

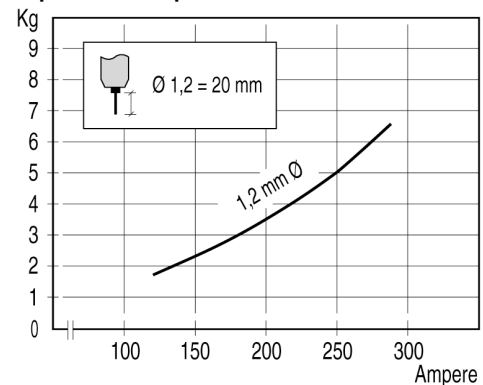
Approvals:

LR SS/CMn S
BV 309L
DNV 309L
GL 4332S
TÜV 09141.00
RINA 309L S
CE

Recommended parameter range:



Deposition rate per hour:



Diam.mm	Product code	Spool weight
1,2	95751012	15 kg BS300
1,2	95751112	5 kg BS200

Note

Strip:
S ≤ 0.03%
P ≤ 0.04%
N ≤ 0.06%