TECHNIWELDUSA

309LT1-1

Specifications / Certifications:

AWS A5.22 E309LT1-1/4

Features

- Excellent usability with stable arc
- Less spattering
- Good bead appearance
- Better slag removal
- Less quantity of welding fume comparable to solid wire

Applications

- Stainless steels and carbon steels
- Stainless steels and low alloy steels

Technical Specifications

- Use 100% CO_2 gas or Ar+20-25% CO_2 gas.
- The optimum flow of CO2 for shielding is 20-25 ℓ/min.
- Protect the weld with a screen to prevent blowholes caused by wind where the wind velocity is 6.56 ft/sec (2m/sec) and more.
- Keep the distance between tip & base metal at 0.59-0.98 in (15-25 mm).
- For multi-layer welding, keep preheat and inter-pass temperature below 302°F (150°C)

Recommended GMAW Weld Parameters:

Flat	
Diameter	**Amps**
0.045”	180-220A
0.062”	200-280A
Horizontal Fillet	
Diameter	**Amps**
0.045”	180-220A
0.062”	200-280A
Vertical Up	
Diameter	**Amps**
0.045”	120-160A
0.062”	160-220A

Typical Chemical Composition:

Chemical	**C**	**Mn**	**Si**	**P**	**S**	**Cr**	**Ni**	**Mo**
AWS	0.04 max	0.5-2.5	1.0 max	0.04 max	0.03 max	22-25	12-14	0.5 max
100% CO_2	0.02	1.30	0.60	0.022	0.006	23.20	12.80	0.02
Ar+20% CO_2	0.03	1.46	0.78	0.025	0.004	23.55	12.71	0.05

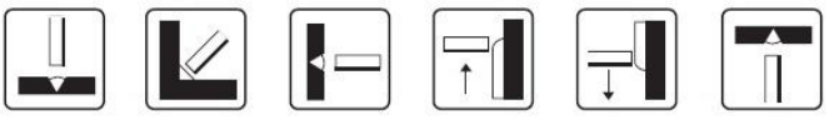
Typical Mechanical Properties:

	Tensile Strength (psi)	**Elongation**	**Impact Value (J)**
AWS	75,419 min psi	30% min	
100% CO_2	84,702 psi	41%	52
Ar+20% CO_2	89,198 psi	41%	67

Diameters & Packages

Diameter		**Lbs**	**Pkg**
0.035”	7/200”	10	Spool
		33	Spool
0.045”	3/64”	10	Spool
		33	Spool
0.062”	1/16”	33	Spool
0.093”	3/32”	10	Box

Welding positions



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