

CSF-309L(P)

For 22%Cr-12%Ni Stainless steel

AWS A5.22 E309LT0(1)-1/4
KS D 3612 YF309LC
JIS Z3323 TS309L-FB0(1)

Applications

CSF-309L(P) is suitable for welding of 22%Cr-12%Ni steel and heat resistant steel and dissimilar joint such as a stainless steel to carbon steel of low alloy steel. Under layer welding on claded side groove claded stainless steel or carbon steel where stainless steel weld metal is overlaid.

Characteristics

- (1) CSF-309L(P) is flux cored wire and designed for Fillet & H-F(All-position) welding with CO₂ gas Shielding.
- (2) It provides the excellent usability with stable arc, less spattering, good bead appearance, better slag removal, and less quantity of welding fume comparable to solid wire.
- (3) Is containing Ferrite of a reasonable quantity and crack-resistance, intergranular corrosion resistance, mechanical properties of weld metal is superior.
- (4) Shield gas is 100%CO₂ or Ar+CO₂ gas.

Notes on usage

- (1) The optimum flow of CO₂ for Shielding is 20~25ℓ/min.
- (2) Protect the weld with a screen to prevent blowholes caused by wind where the wind velocity is 2m/sec and more.
- (3) Keep the distance between tip & base metal at 15~25mm.

Typical chemical composition of weld metal (%)

(Shielding Gas : 100%CO₂)

	C	Mn	Si	P	S	Cr	Ni	FN
CSF-309L	0.03	1.51	0.56	0.015	0.015	23.6	12.8	22
CSF-309LP	0.03	1.33	0.64	0.019	0.006	23.6	13.0	21

Typical mechanical properties of weld metal

(Shielding Gas : 100%CO₂)

	YP N/mm ² (MPa)	TS N/mm ² (MPa)	EL %	IV (J)
				0℃
CSF-309L	424	580	39.0	48
CSF-309LP	427	585	38.0	50

Size & recommended current range (DC +)

Dia. mm (in)	Current(A)	Voltage(V)	Welding Speed(cm /min)
1.2(0.045)	150~300	24~33	20~60
1.6(0.062)	200~400	24~33	20~60

• Approval : CSF-309L : ABS, BV, DNV, GL, KR, LR, NK / CSF-309LP : ABS, BV, DNV, LR