

CSF-309MoL(P)

For 22%Cr-12%Ni-2%Mo Stainless steel

AWS A5.22 E309LMoT0(1)-1/-4
KS D3612 YF309MoLC
JIS Z3323 TS309LMo-FB0(1)

Applications

CSF-309MoL(P) is suitable for welding of 22%Cr-12%Ni-2%Mo steel and heat resistant steel and dissimilar joint such as a stainless steel to carbon steel of low alloy steel. Under layer welding on clad side groove clad stainless steel or carbon steel where stainless steel weld metal is overlaid.

Characteristics

- (1) CSF-309MoL(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 20~25 l/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	Mo	FN
CSF-309MoL	0.028	1.40	0.55	0.015	0.010	23.0	13.0	2.4	19
CSF-309MoLP	0.026	0.74	0.661	0.012	0.009	22.60	12.8	2.3	18

Typical mechanical properties of weld metal

(Shielding Gas : 100% CO₂)

	YP N/mm ² (MPa)	TS N/mm ² (MPa)	EL %	IV J (kgf-m)
				0℃
CSF-309MoL	560	680	33.0	32
CSF-309MoLP	535	695	34.0	30

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-309MoL : ABS