

## MIDALLOY MASTERCOR™ E309LT1-1/4 AP FLUX-CORED WIRE

### CLASSIFICATION

- AWS 5.22 Class E309LT1-1 and E309LT1-4 / ASME SFA 5.22 Class E309LT1-1 and E309LT1-4 flux cored wire.
- UNS# W30935 A# 8 F# 6

### DESCRIPTION

- MIDALLOY Mastercor™ E309LT1-1/4 is a gas shielded flux-cored wire designed for “all position” welding and can be used with 75% Argon 25% CO<sub>2</sub> or 100% CO<sub>2</sub> shielding gas.

### APPLICATIONS

- MIDALLOY Mastercor™ E309LT1-1/4 is used for joining 309 stainless steel.
- MIDALLOY Mastercor™ E309LT1-1/4 is used for dissimilar welds between carbon and low alloy steels to austenitic stainless steels.
- MIDALLOY Mastercor™ E309LT1-1/4 is used for 1<sup>st</sup> layer cladding of carbon steel if no columbium additions are required.

### TYPICAL CHEMISTRY (%)

| C    | Mn  | Si  | Cr    | Ni   | Mo  | P   | S   | N   |
|------|-----|-----|-------|------|-----|-----|-----|-----|
| 0.03 | .95 | .80 | 24.20 | 12.5 | .30 | .03 | .02 | .05 |

Controlled Ferrite WRC 92: 8-15 FN

### TYPICAL MECHANICAL PROPERTIES\*

|                  |            |
|------------------|------------|
| TENSILE STRENGTH | 85,100 PSI |
| YIELD STRENGTH   | 66,900 PSI |
| ELONGATION IN 2" | 38%        |

Note: Mechanical properties shown using 100% CO<sub>2</sub> shielding gas

### OPTIMUM TYPICAL WELDING PARAMETERS (using 100% CO<sub>2</sub> shielding gas)

| DIAMETER | AMPERAGE | VOLTAGE | WFS (IPM) | STICK/OUT   |
|----------|----------|---------|-----------|-------------|
| .045"    | 160-200  | 26-28   | 300-425   | 5/8" / 3/4" |
| 1/16"    | 215-250  | 27-28   | 190-240   | 3/4" / 1"   |

Note: Lower volts by 2 volts when using 75AR/25CO<sub>2</sub>

### STANDARD PACKAGING

- 33 lb. spool

1/5/10

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