

MIDALLOY MASTERCOR™ E309T1-1/4 / E309HT1-1/4 AP FLUX-CORED WIRE

CLASSIFICATION

- AWS 5.22 Class E309T1-1, E309HT1-1, E309T1-4, and E309HT1-4 / ASME SFA 5.22 Class E309T1-1, E309HT1-1, E309T1-4, and E309HT1-4 flux-cored wire.
- UNS# W30931 A# 8 F# 6

DESCRIPTION

- MIDALLOY Mastercor™ E309T1-1/4 and E309HT1-1/4 are gas shielded flux-cored wires designed for all-position welding and can be used with 75% Argon / 25% CO₂ or 100% CO₂ shielding gas.

APPLICATIONS

- MIDALLOY Mastercor™ E309T1-1/4 and E309HT1-1/4 have a nominal composition of 23.5% Cr and 13% Ni, and is used for joining similar alloys in wrought or cast forms.
- MIDALLOY Mastercor™ E309T1-1/4 and E309HT1-1/4 are used for dissimilar welds between Carbon and low-alloy steels to austenitic stainless steels.
- MIDALLOY Mastercor™ E309T1-1/4 and E309HT1-1/4 are used for 1st layer cladding of carbon steel and for welding the stainless steel side of type 304 clad sheets.
- MIDALLOY Mastercor™ E309T1-1/4 and E309HT1-1/4 can be used to weld type 304 base metals where severe corrosion conditions exist that require higher alloy content in the weld metal.

TYPICAL CHEMISTRY (%)

C	Mn	Si	Cr	Ni	Mo	P	S	N	Cu
0.06	1.00	0.80	24.00	12.6	0.30	0.03	0.02	0.05	0.02

Controlled Ferrite WRC 92: 8-15 FN

TYPICAL MECHANICAL PROPERTIES*

TENSILE STRENGTH	89,100 PSI
YIELD STRENGTH	69,800 PSI
ELONGATION IN 2"	35%

Note: Mechanical properties shown using 100% CO₂ shielding gas

OPTIMUM TYPICAL WELDING PARAMETERS (using 100% CO₂ 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 by 2 volts when using 75AR / 25CO₂

STANDARD PACKAGING

- 33 lb. spool

8/04/11

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