

MIDALLOY MASTERCOR® E309LMoT1-1/4 AP FLUX-CORED WIRE

CLASSIFICATION

- AWS 5.22 Class E309LMoT1-1/4 / ASME SFA 5.22 Class E309LMoT1-1/4
- UNS# W30938 A# 8 F# 6

DESCRIPTION

- MIDALLOY MASTERCOR E309LMoT1-1/4 AP is an all position flux-cored stainless steel wire designed to run with 75% Ar - 25% CO₂ or 100% CO₂ .
- This wire has a smooth spray like arc transfer at higher amperages and at lower amperages a globular transfer. The slag is easily removed at all amperages.

APPLICATIONS

- MIDALLOY MASTERCOR E309LMoT1-1/4 AP produces a 316 deposit when overlaying carbon and low alloy steels.
- Applications requiring high strength and resistance to pitting and stress corrosion for use in marine, chemical and petroleum industries.
- Can be used to weld 22% Cr duplex's (UNS S31803) and 25 Cr Duplex's to type 316/316L and to carbon steel.

TYPICAL CHEMISTRY % (DEPOSIT WITH 75%AR25%CO2)

C	Cr	Ni	Mo	Mn	Si	P	S	N
0.03	22.5	13.1	2.40	0.95	0.71	0.019	0.008	0.05

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES

TENSILE STRENGTH	95,000 PSI
YIELD STRENGTH	72,500 PSI
ELONGATION	34 % Min.

WELDING PARAMETERS

SIZE	VOLTS	AMPS	WIRE FEED IPM	STICKOUT	POLARITY	SHIELDING GAS /FLOW
.045	24-33	150-220	240-560	3/4" – 1"	DCRP	75%Argon 25% CO2/35 cfh
.045 Vertical	24-26	120-190	225-450	3/4" – 1"	DCRP	75%Argon 25% CO2/35 cfh
1/16	25-28	160-300	155-320	3/4-1"	DCRP	75%Argon 25% CO2/35 cfh
1/16 Vertical	25-27	170-250	150-250	3/4" – 1"	DCRP	75%Argon 25% CO2/35 cfh

*100% CO2 may be used for flat and horizontal positions. Be sure to raise voltage 2 volts.

STANDARD PACKAGING

- .045" dia. and 1/16" diameters on 33 lb. Spools

3/2/17

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Office and Corporate Warehouse
 630 Axminister Drive
 St. Louis, MO 63026 • 636-349-6000 • 800-776-3300
 Fax 636-349-2240

