

MIDALLOY MASTERCOR™ E309LT0-1/4 F & H FLUX-CORED WIRE

CLASSIFICATION

- AWS 5.22 Class E309LT0-1 and E309LT0-4 / ASME SFA 5.22 Class E309LT0-1 and E309LT0-4 flux cored wire.
- UNS# W30935 A# 8 F# 6

DESCRIPTION

- MIDALLOY Mastercor™ E309LT0-1/4 is a gas shielded flux-cored wire designed for flat and horizontal welding and can be used with 75% Argon 25% CO₂ or 100% CO₂ shielding gas.

APPLICATIONS

- MIDALLOY Mastercor™ E309LT0-1/4 is used for welding type 309 stainless steel to itself.
- Can also be used to join carbon and low alloy steels to austenitic stainless steels.
- Can be used to weld 304 clad sheets and for first layer of cladding carbon steel.

TYPICAL CHEMISTRY (%)

C	Mn	Si	Cr	Ni	Mo	P	S	N	Cu
0.03	1.0	.67	24.60	13.2	1.0	.015	.006	.05	.12

Controlled Ferrite WRC 92: 19 FN

TYPICAL MECHANICAL PROPERTIES*

TENSILE STRENGTH	88,000 PSI
YIELD STRENGTH	69,200 PSI
ELONGATION IN 2"	32%

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"	170-200	27-29	335-440	5/8" / 3/4"
1/16"	210-270	28-31	235-345	3/4" / 1"

Note: Lower volts by 2 volts when using 75AR/25CO₂

STANDARD PACKAGING

- 33 lb. spool

1/6/09

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