

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% CO₂ or 100% CO₂ 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 1st 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% 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 volts by 2 volts when using 75AR/25CO₂

STANDARD PACKAGING

- 33 lb. spool

1/5/10

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