

SelectAlloy 309LCb-AP

Description:

SelectAlloy 309LCb-AP is a gas- shielded, flux cored, stainless steel electrode designed to weld in all positions. It has a nominal weld metal composition of 23.5% Cr, 13% Ni, 0.8 Cb and a maximum carbon content of 0.04%. The columbium forms a stable carbide and makes the weld metal more resistant to intergranular corrosion. **SelectAlloy 309LCb-AP** can be used with 100% carbon dioxide shielding or a blend of 75-80% argon/balance carbon dioxide. Shielding gas mixtures with more than 75-80% argon are not recommended.

Classifications & Approvals:

- E309LCbT1-1, E309LCbT1-4 per AWS A5.22

Characteristics:

SelectAlloy 309LCb-AP provides superb performance characteristics in all positions, using CO₂ or argon +20-25% CO₂ shielding gas. Flat, well washed beads can be achieved with minimal weaving. Spatter is very low and slag peeling is excellent, minimizing cleanup.

Applications:

SelectAlloy 309LCb-AP is used to overlay carbon and low alloy steel. It will produce a columbium stabilized first layer.

Typical Mechanical Properties (CO₂)*:

Ultimate Tensile Strength (psi)	88,100
Yield Strength (psi)	59,900
Percent Elongation	34

*Strength levels will be slightly higher w/Ar+20-25% CO₂

Typical Weld Deposit Chemistry (CO₂)*:

Shielding Gas	C	Cr	Ni	Nb	Mn	Si	N
100CO ₂	0.03	23.60	12.30	0.80	1.10	0.80	0.05

Ferrite Number (WRC, 1992) -15

Typical Welding Parameters (CO₂)*:

Diameter	WFS (ipm)	Amperage	Voltage	ESO (in.)	Dep. Rate (lbs/hr)
.035"	300	110	25	5/8-3/4	3.3
.035"	500	150	26	5/8-3/4	5.4
.035"	600	165	27	5/8-3/4	6.3
.035"	700	175	28	5/8-3/4	7.7
.045"	250	130	24	5/8-3/4	5.4
.045"	300	160	26	5/8-3/4	6.3
.045"	425	200	28	5/8-3/4	9.2
.045"	780	270	34	5/8-3/4	16.2
1/16"	150	170	25	3/4-1	5.4
1/16"	195	215	27	3/4-1	7.0
1/16"	240	250	28	3/4-1	8.6
1/16"	320	305	29	3/4-1	11.5

* Optimum conditions are in **boldface type**. Lower by 2 volts when using Ar+20-25% CO₂.

Rev 0 (09/16/2015)

Notice: The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. Thus the results are not guarantees for use in the field. The manufacturer disclaims any warranty of merchantability or fitness for any particular purpose with respect to its products.