

SelectAlloy 309LT0-3

Stainless Steel / Self Shielded / Flux Cored

PRODUCT DATA SHEET

FEATURES

- Low C, < 0.04 wt%, minimizes carbide precipitation (sensitization) which makes the weld metal more resistant to intergranular corrosion.
- Designed for welding in either the flat or horizontal position where gas-shielding is not possible.
- Arc transfer is globular, with low spatter, and resulting bead is flat and well washed with a fine ripple surface.
- Applications for this alloy type include welding dissimilar metal, such as type 304 SS to mild steel, cladding mild steel or type 304 base metals where corrosion requires to be enhanced, and welding of the stainless steel side of type 304 claddings.

CONFORMANCES

AWS A5.22	E309LT0-3
ASME SFA 5.22	E309LT0-3

DIAMETERS (in [mm])

0.045 (1.2), 1/16 (1.6), 3/32 (2.4)

POSITIONS



SHIELDING GAS

N/A

POLARITY

Direct Current Electrode Positive (DCEP)

TYPICAL WELD DEPOSIT CHEMISTRY (WT%)

Shielding Gas	C	Cr	Cu	Mn	Mo	N	Ni	P	S	Si	WRC-1992 Ferrite
N/A	0.02	24.4	0.14	1.75	0.08	0.12	13.70	0.02	<0.01	0.49	13

Bismuth is not intentionally added and levels are not known to be greater than 0.002 (WT%)

TYPICAL MECHANICAL PROPERTIES

Shielding Gas	Tensile Strength ksi (MPa)	Yield Strength ksi (MPa)	Elongation (%)	Weld Condition	PWHT Temp
N/A	93 (641)	70 (486)	34	As-Welded	-



Notice: Be sure to follow all your employers safety practices, policies and procedures when using this product. Refer to CSA W117.2 and ANSI Z49.1 Safety in Welding, Cutting and Allied Processes for further information and the manufactures SDS sheet. 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. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. 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.

RECOMMENDED WELDING PARAMETERS **

Diameter in (mm)	Shielding Gas	Position	WFS* in/min (m/min)	Amps	Volts	CTWD* in (mm)
0.035 (0.9 mm)	N/A	Flat & Horizontal	450 (11.4)	120	26	3/8 (10)
		Flat & Horizontal	585 (14.9)	145	28	1/2 (13)
		Flat & Horizontal	750 (19.1)	160	32	3/4 (19)
0.045 (1.2 mm)	N/A	Flat & Horizontal	250 (6.4)	120	25	1/2 (13)
		Flat & Horizontal	430 (10.9)	175	28	5/8 (16)
		Flat & Horizontal	575 (14.6)	205	32	1 (25)
1/16 (1.6 mm)	N/A	Flat & Horizontal	215 (5.5)	165	26	5/8 (16)
		Flat & Horizontal	255 (6.5)	200	28	3/4 (19)
		Flat & Horizontal	350 (8.9)	250	32	1 (25)
3/32 (2.4 mm)	N/A	Flat & Horizontal	125 (3.2)	220	25	1 1/2 (38)
		Flat & Horizontal	180 (4.6)	300	28	1 1/2 (38)
		Flat & Horizontal	240 (6.1)	330	32	1 3/4 (44)

* WFS = Wire Feed Speed, CTWD = Contact Tip To Work Distance

**The parameters listed are recommended starting points of operation and the ranges for amperage, wfs, and voltage could be extended based on fitness for application. For products with "all-position" capability, as determined and listed in classification, the position recommendation can be determined based on operator skill and material thickness and isn't limited to the listing.

PACKAGING (lbs (kgs))

33 (15) Spools, 60 (27.2) Coils, 500 (226.8) Round Drum, 800 (362.9) Hex Drum, 900 (408.2) Hex Drum

*Some packaging options may not be available depending on diameter and product. Special package options may be available upon request.

STORAGE AND HANDLING

All products should be stored in original packaging, in dry conditions and handled with care. For more information refer to our website.



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