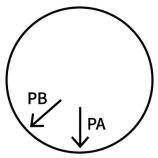
SW-309LNS Cored

Classification

AWS AWS A5.22 / ASME SFA-5.22
EC309L
EN ISO 17633-A-T 23 12 L M M13/I1

Welding Positions





Features

- Non-slag type
- Low spatter

Polarity

DC+

Application Areas

- Automotive mufflers
- Welding of dissimilar metals such as stainless and carbon a low alloy steels

Shielding Gas

100% Ar
Ar + 2% O2

Typical Chemical Composition of All-Weld Metal (wt%)

Shielding Gas	C	Si	Mn	P	S	Cu	Ni	Cr	Mo
Ar + 2% O2	0.03	0.55	1.80	0.020	0.010	0.13	13.0	24.0	0.13

Typical Mechanical Properties of All-Weld Metal

Shielding Gas	Yield Strength MPa(ksi)	Elongation (%)
Ar + 2% O2	590 (86)	45

Diameter / Welding Parameters / Packaging

Wire Diameter mm(in)	Current (A)
1.2 (0.045)	180~250