K-309T

AWS E309T0-1/-4
JIS YF309C
KS YF309C

FOR STAINLESS STEEL

Typical applications

K-309T is formulated for MAG welding of 22%Cr-12%Ni stainless steels. Typical applications is for welding of dissimilar steels, such as 304 to mild steel or low alloy steels.

Characteristics on Usage

① K-309T is a titania type of flux cored wire for cladding and dissimilar joint welds.
② It is designed for operation in the flat position and for welding horizontal fillet welds.
③ Weld metals contain comparatively much more ferrite in their austenitic, therefore they provide better weldability together with superior heat resistance, and corrosion resistance.
④ The shielding gas should be used 100%CO_2 and 80%Ar+20%CO_2 for welding.
⑤ Refer to page 150 for more information on usage.

Typical chemical composition of all-weld-metal (%)

Shielding Gas	C	Si	Mn	Cr	Ni
CO_2	0.05	0.58	1.45	23.5	13.0
Ar+20%CO_2	0.04	0.78	1.93	23.7	13.4

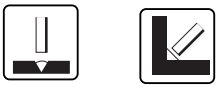
Typical mechanical properties of all-weld-metal

Shielding Gas	T · S N/mm²{kgf/mm²}	El (%)
CO_2	590 {60}	36
Ar+20%CO_2	610 {62}	35

Sizes available and recommended currents (DC wire⊕)

Dia. (mm)	Amp.	Electrode extensin (mm)
1.2	100~220	10~20
1.6	160~260	15~25

Welding positions



Approved by

ABS, BV, DNV, KR, LR, NK, JIS