

TASETO Welding Materials

Stainless Steel Electrodes

For Flux Cored Arc Welding

GFW309L

Applicable Specification

JIS Z 3323 TS309L-FB0
AWS A5.22 E309LT0-1/4

● Applications and Characteristics

TASETO GFW309L is the same composition as GFW309, except low carbon content less than 0.04%. So this wire is suitable for welding first layer of low carbon type stainless steel overlay or clad steel.

● Notes on Usage

* Please refer "Guideline for Welding Stainless Steel with GFW Wires".

● Chemical Composition of All Weld Metal (%)

	C	Si	Mn	P	S	Ni	Cr	Mo	Cu
Typical	0.025	0.61	1.31	0.015	0.004	12.55	24.12	0.02	0.02

● Ferrite Content of All Weld Metal

* Typical Ferrite Content: 14.2% (Schaeffler's Diagram)
>18FN (DeLong's Diagram)
22% (Ferrite Scope)

● Mechanical Properties of All Weld Metal

	0.2% Proof Stress (MPa)	Tensile Strength (MPa)	5D Elongation (%)
Typical	431	595	35.0

● Sizes Available, Shielding Gas

Size (mm)	Shielding Gas
1.2	CO ₂ or Ar+20%CO ₂ , 20L/min
1.6	CO ₂ or Ar+20%CO ₂ , 20L/min