

TASETO Welding Materials

Stainless Steel Electrodes

For Flux Cored Arc Welding

MC309L

Applicable Specification

JIS Z 3323 TS309L-MM0
AWS A5.22 EC309L

● Applications and Characteristics

TASETO MC309L is a metal flux cored wire and used for welding of 1st layer on Type 304 or 304L clad steel, welding of dissimilar metals such as Type 304 or 304L stainless steel to carbon steel or low alloy steel, and welding of first layer on carbon steel or low alloy steel of overlay welding.

It makes less slag and produces a beautiful bead form.

As MC309L can be used with higher current compared to slag type flux cored wires, the rate of deposition is high, and enable efficient high speed welding.

● Notes on Usage

* Please refer "MC Wires".

* Use mixed gas (Ar+20%CO₂) as shielding gas and control the flow rate at 20L/min.

* Avoid placing the unsealed wire in humidified location.

* Perform welding in an environment where the wind velocity is no more than 1 m/sec.

● Chemical Composition of All Weld Metal (%)

	C	Si	Mn	P	S	Ni	Cr	Mo	Cu
Typical	0.035	0.38	1.62	0.027	0.003	12.29	23.96	0.01	0.02

● Mechanical Properties of All Weld Metal

	0.2% Proof Stress (MPa)	Tensile Strength (MPa)	5D Elongation (%)	Absorbed Energy (J at -196°C)
Typical	464	604	34.4	24.5, 19.6, 24.5

● Ferrite Content of All Weld Metal

* Typical Ferrite Content: 12.1(Schaeffler's Diagram)

● Corrosion Resistance of All Weld Metal

* Typical Corrosion Resistance 180° bend without any defects
(Copper Sulfate-Sulfuric Acid Test : PWHT650°C × 2h)

● Sizes Available and Recommended Welding Conditions(DCEP)

Size (mm)	Welding Current (A)	Arc Voltage (V)	Shielding Gas
1.2	160~280	29~39	Ar+20%CO ₂ , 20L/min
1.6	200~340	31~42	Ar+20%CO ₂ , 20L/min