

AWS CLASSIFICATION A5.22-95 E309LT0-X

DESCRIPTION

Stoody[®] FH stainless steel, flux cored wires are designed for flat and horizontal welding applications, using either 100% CO₂ (X=1) or Argon / CO₂ (X=4) gas mixtures. These wires exhibit a spray like arc transfer with very low levels of spatter, a slag system that is essentially self-releasing, a smooth evenly rippled bead appearance, and deposition rates which are obtained at lower levels of heat input than competitive products.

Stoody[®] 309LT-1 FH wires can be used to join AISI 309 steels. It is also used to join AISI 304 to carbon and low alloy steels.

TYPICAL DEPOSIT CHEMISTRY (wt%)

GAS	75 Ar / 25 CO ₂	100% CO ₂
Carbon	0.02	0.02
Manganese	1.7	1.6
Silicon	0.8	0.7
Chromium	23.5	23.0
Nickel	12.6	12.6
Ferrite Number	15	15

NOTES:

- Chemical composition values are typical and were developed using in accordance with AWS A5.22-95 procedures. Actual test results may vary depending on welding parameters and base metal composition.
- Ferrite values were determined with the Magne Gage. Ferrite values may vary depending on specific operating parameters.

STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
.035" (0.9mm)	25# WB, Can Pack	11919600
.045" (1.2mm)	33# WB, Can Pack	11909300
1/16" (1.6mm)	33# WB, Can Pack	11909700

OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS (DCEP)

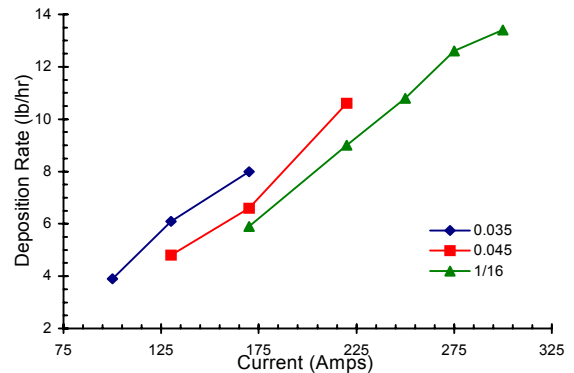
	Low	Optimum	High
.035" (0.9mm)			
Amps	120	150	180
Volts	24	25 / 26	28
WFS, in/min	375	460	550
(m/min)	(9.5)	(11.7)	(14.0)
.045" (1.2mm)			
Amps	135	200	250
Volts	23	26	31
WFS in/min	200	350	450
(m/min)	(5.0)	(8.9)	(11.4)
1/16" (1.6mm)			
Amps	200	250	300
Volts	24 / 26	26 / 28	28 / 30
WFS in/min	175	250	325
(m/min)	(4.5)	(6.4)	(8.3)

NOTES:

- 3/8" - 1/2" (10-12mm) electrical stickout.
- When using Argon / Carbon Dioxide mixtures, voltage may be reduced by up to one volt to improve weldability and bead appearance.

TYPICAL DEPOSIT CHARACTERISTICS

GAS	75 Ar / 25 CO ₂	100% CO ₂
Tensile Strength, Ksi (MPa)	84 (585)	83 (580)
Elongation (%)	34	33
Yield Strength, Ksi (MPa)	61 (420)	61 (420)



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