

AA 309LNb

CATEGORY FCAW Flux-Cored

TYPE Rutile flux cored stainless steel welding wire with exceptional Weldability for use with M21 and Co2

APPLICATIONS Cladding mild and low alloyed steels in offshore and or chemical plants in case AISI 347 or AISI 321 are required as clad layer

PROPERTIES Smooth drop transfer and stable arc with no spatter losses.
Excellent productivity and weldability, better wetting properties compared to solid wires.
Excellent weld metal quality and X-ray soundness and excellent slag removal.
Excellent for use in position and down hand as well.
High resistance against moisture pick up

CLASSIFICATION

AWS	A 5.22: E 309LCb T0-1
EN ISO	17633-A: TZ 23 12 Nb RM 3
DIN: W.Nr.	1.4556
DIN	8556: 23 13 Nb

SUITABLE FOR For steel cladding applications when AISI 347 or 321 is required in the first layer

APPROVALS CE approved

WELDING POSITIONS:



ALL-WELD METAL ANALYSES %

C	Mn	Si	Cr	Ni	Nb	S	P
0.03	1.40	0.70	23.0	12.5	0.80	0.08	0.020

MECHANICAL PROPERTIES

Heat treatment	RP0,2 (N/mm ²)	Rm (N/mm ²)	A5 (%)	Impact energy (J) ISO-V			Hardness HRc / HV
				+20C	0C	-20C	
AW with M21	480	650	35	>50			

AW = as welded

WELDING PARAMETERS PACKING

D (mm)	Welding Parameters			Packing		
	Voltage (V)	Current (A)	spool type	kg / spool	kg / pallet	
1.2	23-35	100-270	K-300	15	1080	
1.6	23-37	150-400	K-300	15	1080	

REDRYING TEMPERATURE 150°C / 24hr