

# GFC 309L



CLASSIFICATION : AWS A5.22 E309LT1-1/4 JIS Z3323 YF 309LC

## CHARACTERISTICS :

GFC 309L(for all-position operation) is used to join similar 309L alloy or join 300 series stainless steel to carbon or low alloy steels.it is also recommended for use as the first layer in a single or multilayer surfacing of non-alloy and low-alloy steels to give a 304L deposit. Manufactured under a quality system certified to ISO9001 requirements.

## TYPICAL APPLICATIONS:

Used for welding similar alloys in wrought or cast form; to weld type 304 base metals when severe corrosion conditions exist; and welding dissimilar steels.

## Characteristics on Usage:

Generally used with 100% CO<sub>2</sub> shielding gas or mixtures of Ar + 20-25% CO<sub>2</sub>. Stable arc transfer and ideal slag removal guarantee that slag comes off easily, creating a smooth and fine bead surface.

## TYPICAL WELD METAL ANALYSIS (%)

C	Mn	Si	P	S	Cr	Ni	Mo	Cu
0.030	1.42	0.45	0.018	0.012	23.4	12.6	0.50 max	0.50 max

## MECHANICAL PROPERTIES OF THE WELD METAL (RANGE)

Ult. Tensile Strength MPa	Elongation (%) (L=4D)
560	40

## RECOMMENDED CURRENT AND PACKING DATA

Dia. mm	1.2	1.6
Current	F HF 140 ~ 240 23 ~ 33 V	200 ~ 300 27 ~ 32
Amp	V OH 120 ~ 200 24 ~ 30 V	- - - -

## Package

Dia. mm	1.2 1.6
Spool kg	12.5 12.5