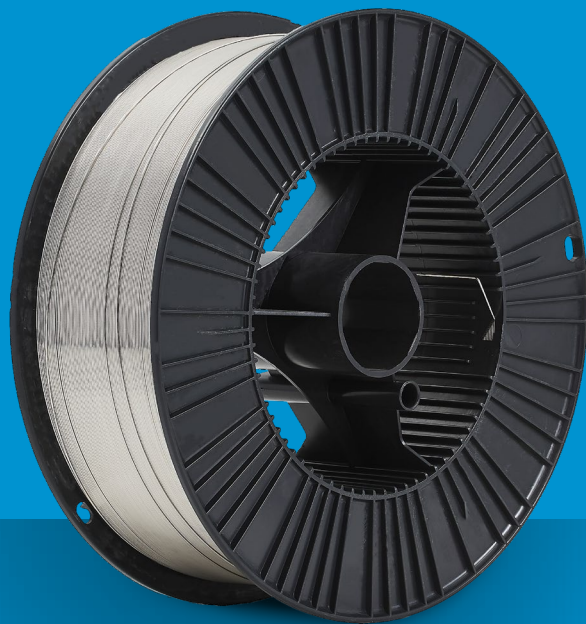
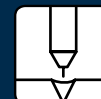
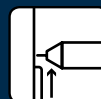


VERTI-COR 309LT

PRODUCT DATA SHEET



VERTI-COR STAINLESS STEEL FLUX CORED WIRES; 309LT- ALL POSITIONAL CAPABILITIES



VERTI-COR 309LT

- Vacuum Sealed in Aluminised Plastic Packs.
- Formulated for CO₂ or Argon + 18-25% CO₂ Shielding gases.
- High Deposition Rate Welding of Stainless Steels.

CLASSIFICATIONS:

AWS/ASME-SFA A5.22:

E309LT1-1 (CO₂) /
E309LT1-4 (Ar + 18-25%CO₂).

RECOMMENDED SHIELDING GAS:

AS 4882:

ISO 14175 / AWS A5.32:

SG-C

C1

SG-AC-18, or SG-AC-20

M21

Welding grade CO₂ or Ar+CO₂ (18-25%)

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

	USING CO ₂ :	ARGON + 18-25% CO ₂ :
0.2% Proof Stress	410 MPa	430 MPa
Tensile Strength	550 MPa	580 MPa
Elongation	40%	38%

TYPICAL ALL WELD METAL ANALYSIS:

USING WELDING GRADE CO₂:

C:	0.03%
Mn:	1.12%
Si:	0.60%
Cr:	23.6%
Ni:	13.0%
P:	0.023%
S:	0.003%

DESCRIPTION AND APPLICATIONS:

Verti-Cor 309LT is a gas shielded stainless steel flux cored wire developed for a wide range of positional and downhand welding applications on matching 309 and 309L stainless steels.

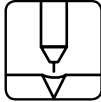

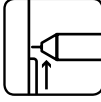
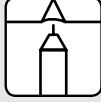
Verti-Cor 309LT is suitable for the dissimilar welding of other "300 series" austenitic stainless steels to mild or low alloy steels and for the welding of selected "400 series" ferritic stainless steels, such as 3Cr12.

The rutile type flux core gives smooth arc transfer characteristics and very low spatter levels with both CO₂ and Argon + 18-25% CO₂ shielding gases. The fast freezing slag gives excellent weld pool control resulting in smooth mitre to slightly convex fillet welds in the flat, horizontal-vertical, vertical-up and overhead welding positions.

Actual weld metal mechanical properties achieved with Verti-Cor wires are influenced by many factors including base metal analysis/heat input used, shielding gas selection, number of weld passes and run placement etc. Please contact CIGWELD for welding procedure recommendations.

OPERATING DATA:

All welding conditions recommended below are for use with semi-automatic operation, DC electrode positive and welding grade CO₂ shielding gas with a flow rate of 15-20 litres/min.

WIRE DIAMETER (MM)	CURRENT RANGE (AMPS)	VOLTAGE RANGE (VOLTS)	CTWD	WELDING POSITION	
1.2 1.6	150-250 300-400	23-28 28-35	15-20 25-30		Flat
1.2 1.6	150-250 250-350	23-28 28-35	15-20 25-30		HV Fillet
1.2 1.6	120-180 200-250	22-27 23-27	15-20 20-25		Vertical up
1.2 1.6	140-180 290-250	22-27 23-27	15-20 20-25		Overhead

These machine settings are a guide only. Actual voltage, welding current and CTWD used will depend on machine characteristics, plate thickness, run size, shielding gas and operator technique etc.

COMPARABLE CIGWELD PRODUCTS:

Autocraft 309LSi GMAW Wire	AWS A5.9: ER309LSi
Comweld 309L GAS/TIG rod	AWS A5.9: ER309L
Satinchrome 309L-17 Electrode	AWS A5.4: E309L-17

PACKAGING DATA:

WIRE DIAMETER (MM)	TYPE	PACK WEIGHT	PACK PART NO.
1.2	Spool	15kg	722881
1.6	Spool	15kg	722882



P/N: 722881



P/N: 722882

