



## ENAR WELD BRAZE PVT. LTD

A-112, DDA INDUSTRIAL SHEDS,  
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### KISWEL K-309LF

#### Classifications:

EN ISO 17633-A: 2008: T 23 12 L R C/M 4  
EN ISO 17633-B: 2008: TS309L-FB0  
AWS A5.22-07: E309LT0-1/4

KS D 3612: YF-309LC  
JIS Z 3323: TS309L-FB0

#### Typical Chemistry Composition of Weld Deposit:

Shielding Gas	C	Si	Mn	Cr	Ni
CO <sub>2</sub>	<0.04	<1.00	0.50 – 2.50	22.00 – 25.00	12.00 – 14.00

#### Description:

- Dissimilar joint welds; of and between high-strength, mild steels and low allowed QT-steels, stainless, ferritic Cr- and austenitic Cr-Ni-steels, manganese steels  
Cladding; for the first layer of corrosion resistant weld claddings on ferritic-perlitic steels in boiler and pressure vessel parts up to fine-grained steel S500N.
- Wire is a titania type of flux cored wire for flat and horizontal position welding and it provides better weldability together with excellent corrosion resistance.
- Wire has low spatter, easy slag removal and good weld soundness.

#### Typical Mechanical Properties:

Yield Strength  
(Mpa)  
min. 390

Tensile Strength  
(Mpa)  
Min. 520

Elongation  
(%)  
min. 35