



KISWEL

KISWEL K-309LF

Classifications:

EN ISO 17633-A: 2008: T 23 12 L R C1/M21 3
EN ISO 17633-B: 2008: TS309L-F C1/M21 0
AWS A5.22: E309LT0-1/4

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

Typical Chemistry Composition of Weld Deposit:

| C | Si | Mn | Cr | Ni | Mo |
|-------|-------|-------------|---------------|---------------|-------|
| <0.04 | <1.00 | 0.50 – 2.50 | 22.00 – 25.00 | 12.00 – 14.00 | <0.50 |

Description:

- For welding of Stainless Steels and Unalloyed or Low Alloyed Steels as well as cladding applications on Low Alloyed Steels.
- Wire has low spatter, easy slag removal and good weld soundness.
- The said wire is available in Ferrite No. 5-12 or Ferrite No. 11-16

Typical Mechanical Properties:

| Yield Strength (Mpa) | Tensile Strength (Mpa) | Elongation (%) | Impact Value (J) |
|----------------------|------------------------|----------------|------------------|
| min. 320 | Min. 520 | min. 30 | 43 (-30°C) |

Packaging:

MIG/MAG Wire (∅ in mm): 1.20 MM in 12.50 Kg Spools

Welding Parameters:

| Wire Diameter | Shielding Gas | Current (A) | | Voltage (V) | |
|---------------|-----------------|-------------|------|-------------|------|
| | | Min. | Max. | Min. | Max. |
| 1.20 mm | CO ₂ | 130 | 280 | 22 | 30 |



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