Cor-A-Rosta® 309L

TOP FEATURES

- For welding stainless to mild steel and buffer layers in clad steel
- Excellent weldability and self releasing slag
- High resistance to embrittlement
- Smooth regular bead appearance

TYPICAL APPLICATIONS

- Steel construction.
- Maintanance and regeneration - buffer layer.

CLASSIFICATION

AWS A5.22	E309LT0-1/-4
EN ISO 17633-A	T 23 12 L R C/M 3

CURRENT TYPE

DC+

WELDING POSITIONS

Flat/Horizontal

SHIELDING GASES (ACC. EN ISO 14175)

M21	Mixed gas Ar+ (>15-25%) CO_2
C1	Active gas 100% CO_2
Gas flow	15-25l/min

APPROVALS

LR	TÜV
+	+

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

Shielding gas	C	Mn	Si	Cr	Ni	FN (acc.WRC 1992)
M21/C1	0.03	1.4	0.6	24	12.5	15

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)	
						+20°C	-110°C
Required: AWS A5.22			not specified	min. 520	min. 30		
EN ISO 17633-A			min. 320	min. 510	min. 25		
Typical values	M21/C1	AW	445	560	36	45	40

* AW = As welded

PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.2	SPOOL (S300)	15.0	585209

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:

Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.