

NST A-309L

AWS: A5.22 -95: E309LT 1-4

NS-EN ISO 17633-A: T 23 12 L P M1

EN ISO 9606-1: FM5



Flux cored wire for positional welding of corrosion resistant materials against carbon steel, and for cladding of carbon steels.

General description:

NST A-309L is a rutile flux cored wire for positional welding of corrosion resistant materials such as AISI 304 etc. against carbon steel. The flux cored wire uses an Argon/CO₂ mixed shielding gas.

This ensures a user friendly and stable welding arc, less spatter, good visual bead appearance and smooth transition to the parent materials.

The newly developed slag system gives the welder better control of the weld pool and this wire can now be welded without weaving in all positions

It is also suitable for use with ceramic backing for single sided welding.

NST A-309L's chemical composition ensures a weld metal equivalent of AISI 304 in the first layer of a cladding process.

Welding positions:



Welding current:

DC+

Gas flow:

15-23 l/min.

Typical chemical composition of all-weld-metal:

C	Si	Mn	P	S	Cu	Ni	Cr	Mo	
0.018	0.58	1.82	0.019	0.002	0.03	12.92	24.17	0.01	

Shielding gas:

Argon+ 18-25% CO₂.

Typical mechanical properties of all-weld-metal:

Yield and Tensile Strengths				
Yield Mpa(Rp0.2)	Tensile Mpa(Rm)	Elongation %		
430	562	41		

Guidance - Ampere (DC+):

Electrode diameter			
Ampere / Volt			

Packaging information:

1,2mm x 5,0kg D200
1,2mm x 12,5kg D300

Approvals:

DNV, CE

Reference / date:

NST A-309L,
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Perfect Welding

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