



WA. ALLOY CO.

WASHINGTON ALLOY'S Quality Management System is Certified to ISO 9001:2008 Cert # 05-R0925

309LT-3 Stainless Steel Flux Cored

U.S. ALLOY CO.
dba Washington Alloy
7010-G Reames Rd.
Charlotte, NC 28216
www.weldingwire.com



American Welding Society
Sustaining Company Member



ALLOY DESCRIPTION AND APPLICATION;

309L is an austenitic stainless steel used to weld base metal of similar composition and 300 types stainless to carbon or low alloy steels, also the low carbon grades stainless. The low carbon reduces carbide precipitation and may be used as a buffer layer when cladding mild steel with austenitic stainless.

TYPICAL FCAW WELDING PROCEDURES; DCEP

Wire Diameter	Wire Speed (ipm)	Amps	Volts	Electrical Stick-out
0.035	275-520	75-140	24-28	1/2-1"
0.045	190-480	125-195	25-31	3/8-1"
1/16"	155-320	130-260	26-32	1/2-1"

Deposition rate lbs/hr: .035" = 3-6 lbs, .045" = 4-8 lbs, 1/16" = 8-15lbs

Procedures may vary with change in position, base metals, filler metals, equipment and other changes.

CHEMISTRY (%) for Undiluted WELD METAL & PROPERTIES (AWS Requirements)

Carbon	0.04	Molybdenum	0.75
Manganese	0.5-2.5	Phosphorus	0.04
Silicon	1.0	Sulfur	0.03
Chromium	22.0-25.0		
Nickel	12.0-14.0	Copper	0.75
	Elongation	30% min.	
	Tensile Strength (psi)	75,000 min.	

Iron balance and all single values are maximum percentages unless noted

AVAILABLE SIZES: TSF 309LT-3 = .035, .045, 1/16

Other sizes available – please inquire

SPECIFICATIONS; AWS A5.22 E309LT0-3 or E309LT1-3

ASME SFA 5.22 E309LT0-3 or E309LT1-3

ASME F - 6, A -8

T0 = flat and horizontal; T1 = all position; -3 = NO GAS (SHELF-SHIELDED)

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