

## ❖ Product Description

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|--|---|
| I. Gas shielded, rutile type FCW wire                    | IV. Uniform and good weld bead appearance |
| II. Low fumes, very less spatter and slag removed easily | V. Typical 23%Cr-12%Ni weld deposit       |
| III. Excellent crack resistant and corrosion resistant   | VI. Radiographic weld quality             |

## ❖ Range of Application

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|---|--|
| I. Extremely good for welding of dissimilar metals such as stainless steel and carbon steel or stainless steel and low alloy steels | II. For use in welding heavy equipment such as cranes, lifters, shafts etc |
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## ❖ Classification

- AWS/SFA 5.22 E309LT1

## ❖ % Chemical Composition

Type of Wire		C	Mn	Si	S	P	Mo	Cr	Ni	Cu
E309LT1	Min	-	0.50	-	-	-	-	22.0	12.0	-
	Max	0.04	2.50	1.0	0.03	0.04	0.75	25.0	14.0	0.75

## ❖ Mechanical Properties of all weld metal`

Condition	UTS, MPa (Min)	YS, MPa (Min)	% Elongation	Charphy "v" Notch Impact @ -30°C
PWHT	520	-	30	-

## ❖ Wire Size & Welding Position

- Diameter in mm- 1.2, 1.6
- Weld Position- All position

## ❖ Current & Gas Flow

- DCEP; 18-25lit/min

## ❖ Packaging

- Standard packaging in 15kg Spool form

### Special Notes: -

- (1) All the value above mentioned are typical values.
- (2) Usually all chemistry and mechanical properties will depend on actual wire chemistry and arc voltage used for welding.

### **SHAKUNT ENTERPRISES PRIVATE LIMITED**

**Corporate Office:** - 619/A, EMMAR DIGITAL GREEN, 6th Floor, Sector-61, GURUGRAM (HARYANA)-122102  
E-Mail:- [info@shakunt.com](mailto:info@shakunt.com)

**Ludhiana Works:-** B-XXIX-595/5,Campa Cola Road,Dhandari Kalan Industrial Area-C,Ludhiana (PUNJAB) INDIA

**Dharwad Works:-** Plot no.577 C & D,Belur Industrial Area,Dharwad-580011 (KARNATAKA) INDIA

**Vadodara Works:-** 67-A,G.I.D.C,Majusar,Savli,Vadodara-397115 (GUJARAT) INDIA