



Stainless Steel Flux Cored Wire E309LT - 1

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◆ INTRODUCTION

Aufhauser E309LT-1 is most frequently used for base metals of similar composition such as AISI Types 301, 302, 304, 305 and 308. The 0.04% maximum carbon content allows for increased resistance to intergranular corrosion and also minimizes carbide precipitation. These wires have been developed for use with 100% Co₂ or 80% Ar/20% Co₂ shielding gas. The ability of operating over a wide range of current settings permits deposition rates that are nearly 4 times greater than covered electrodes and up to 50% greater than solid MIG wire. Although the cost per pound of Stainless Steel Flux-Cored wires may be more than that of coated electrodes or solid MIG wire, your cost per pound of deposited weld metal is greatly reduced because of the higher deposition efficiency and lower operational costs. The true stainless steel sheath used in manufacturing Aufhauser Flux-Cored Stainless is your guarantee of smooth performance, x-ray quality welds and a beautiful stainless steel bead appearance. Spatter is extremely low and slag is self-peeling.

◆ APPLICATIONS

- Welding similar alloys in wrought or cast forms
- Welding dissimilar metals, such as: joining Type 304 to mild steel, welding the stainless steel side of Type 304 clad steels, and applying stainless steel sheet linings to carbon steel sheets
- Occasionally used for welding Type 304 base metals in severe corrosion conditions.
- Used for first layer cladding of carbon steel if no columbium additions are required.

◆ CHEMICAL COMPOSITION

<u>Carbon</u>	<u>Chromium</u>	<u>Nickel</u>	<u>Molybdenum</u>	<u>Manganese</u>	<u>Silicon</u>	<u>Phosphorus</u>	<u>Sulfur</u>
0.04	19.0-21.0	9.0-11.0	0.5	0.5-2.5	1.0	0.04	0.03

◆ PHYSICAL and MECHANICAL PROPERTIES

Tensile Strength:	75,000 psi
Density:	
Elongation, min. %:	30

◆ SPECIFICATIONS MEET or EXCEED

- AWS: A5.22
- ASME: SFA 5.22

◆ STANDARD SIZES AND DIAMETERS

- Diameters: .035", .045" and 1/16"