



# Stainless Steel Flux Cored Wire



## Code & Specification

ASME SFA/AWS A5.22 E309LT1-1 (CO<sub>2</sub>) E309LT-4 (Argon +20-25% CO<sub>2</sub>)

## Description

**BLUME® E309LT1-1/4** is a stainless steel flux cored wire with all positional capabilities. Vacuum sealed in aluminised plastic packs. Formulated for CO<sub>2</sub> or Argon +20-25% CO<sub>2</sub> shielding gases. High deposition rate welding of stainless steel. Welds well in all positions. Excellent welder appeal. Provides a low spatter hence requiring less clean-up. Good weld soundness and extended shelf-life. Fast freezing and self detaching slag. Provides spray-like arc transfer and high moisture resistance.

## Applications

Used for joining common austenitic stainless steel such as Type 304, 304L, 309, 309L. It is often used in dissimilar welding, such as stainless steel to carbon steel, low alloy steel, heat resistant steel and clad steel.

## Mechanical Properties

	As-welded (Argon +20-25% CO <sub>2</sub> )	As-welded (CO <sub>2</sub> )
Yield Strength, MPa	415	410
Tensile Strength, MPa	556	540
Elongation, %(L=4d)	36	38

## Undiluted Weld Metal Analysis (wt%)

		Using CO <sub>2</sub>		
C	Mn	Si	Cr	Ni
≥ 0.03	1.00 - 2.00	0.60 - 0.80	23.0 - 24.0	12.5 - 13.5
P	S			
≤ 0.04	≤ 0.03			

## Suggested Welding Parameters (DC+)

Diameter	Flat		Vertical-up		Overhead	
	Volts	Amps	Volts	Amps	Volts	Amps
1.2mm (.045")	23 - 28	150 - 250	22 - 27	120 - 180	22 - 27	140 - 180
1.6mm (1/16")	28 - 34	280 - 400	23 - 27	200 - 250	23 - 27	190 - 250

## Packaging

15 kgs (33 lbs) [Net Weight] Plastic spools with OD = 270mm (11")

## Approvals



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