

NST 309MoLT

AWS: A5.22-95 E309LMoT 0-4
NS-EN ISO 17633-A: T 23 12 2 L R M3
EN ISO 9606-1: FM5



Flux cored wire for flat position and fillet welding of carbon steels against stainless steel materials such as AISI 316 etc.

General description:

NST 309MoLT is a flux cored wire for flat position (PA) and fillet welding (PB and PC) of stainless steel materials such as AISI 316 and similar against carbon steel.

The wire is also suitable for cladding of carbon steel where a Mo stainless cladding is needed.

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.

NST 309MoLT has a slag freezing system which is slightly slower than wires designed for positional welding.

This makes this wire suitable for flat position and fillet welds.

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

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	
0,020	0.63	1.18	0.024	0.002	0.14	12.88	22.82	2.49	

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 %		
533	690	29		

Guidance - Ampere (DC+):

Electrode diameter			
Ampere / Volt			

Packaging information:

0,9mm x 12,5kg D300
1,2mm x 5,0kg D200
1,2mm x 12,5kg D300

Approvals:

CE

Reference / date:

NST 309MoLT,
English, 11.10.2019.