

ROYAL PRIME-309L

STAINLESS STEEL FLUX-CORED WELDING WIRE
FOR WELDING 24/12 STEEL

BASIC ALLOY: FE, MN, CR, NI
AWS/SFA-5.22: E309L T 1/4
EN ISO 17633-A : T 23 12 L P C1 2

KEY FEATURES:

ROFIL-309L is a titania type, all-position, flux-cored wire designed for MAG welding of low carbon 24%Cr-12%Ni stainless steels. . The wire have smooth and stable arc with good slag detachability. The weld metal contains comparatively much more ferrite in their austenitic, therefore providing better weldability together with superior heat and corrosion resistance.

APPLICATIONS

- It is used for dissimilar weld joints between high strength, mild steels and low-alloyed QT-steels, stainless, ferritic Cr and austenitic Cr-Ni steels, manganese steels

SHEILDING GAS

- Welding with CO2 gas and Ar+ CO2 gas mixture

CHEMICAL COMPOSITION:

C	Mn	Si	S&P	Ni	Cr	Mo
0.030 Max.	0.50-2.50	1.00max.	0.030 Max	12.00-14.00	22.00-26.00	0.75 max.

MECHANICAL PROPERTIES

UTS (N/mm2)	EL % (l=5d)	Ferrite Content
520 Min.	30 Min.	8-12 FN

WELDING POSITION



DIEMENSION, CURRENT CONDITION & PACKING DATA

Size (mm)	Size (inch)	Current Condition (DC+)	Voltage (V)	Spool packing 12.5 kg.	Spool packing 15kg
1.20	3/ 64"	120-300	18-22	✓	✓
1.40	1/ 18"	160-340	18-22	✓	✓
1.60	1/ 16"	180-360	18-22	✓	✓
2.00	5/64"	200-380	18-22	✓	✓