



Cromacore DW 309LNb

FCAW - Flux cored arc welding
Stainless Steel

Date: 2008-05-20
Revision: 2

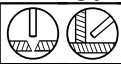
Description:

Cromacore DW 309LNb is a rutile flux cored wire which deposits a low carbon, Nb-stabilised 24% Cr / 13% Ni stainless steel weld metal with a ferrite level of FN ~18. The wire operates with a very stable, spatter free arc producing a bright, smooth weld bead surface and self-releasing slag. Cromacore DW 309LNb is used mainly for overlay welding of 2.25Cr-1Mo steels

Applications:

Overlay welding of low alloy steels.
Buffer layer on clad steel joints.

Welding positions:



Welding current:

DC+

Deposition efficiency:

87%

Shielding gas:

80% Ar + 20% CO₂, 22-25 l/min.
100% CO₂, 22-25 l/min.

Stick-out:

15-25 mm

Ferrite content:

FN ~18

Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min			0.5			18.0	12.0
Typical	0.030	0.34	1.27	0.021	0.003	23.46	12.81
Max	0.04	1.0	2.5	0.04	0.03	25.0	14.0

	Nb	N
Min	0.7	
Typical	0.75	0.019
Max	1.00	

Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Rp0.2%:		427
Tensile Strength, Rm:	520	579
Elongation, A5	30	36
Impact energy, CV:		0°C•50 J

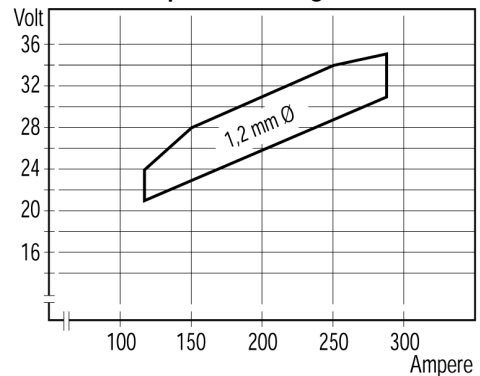
Classification:

AWS A5.22

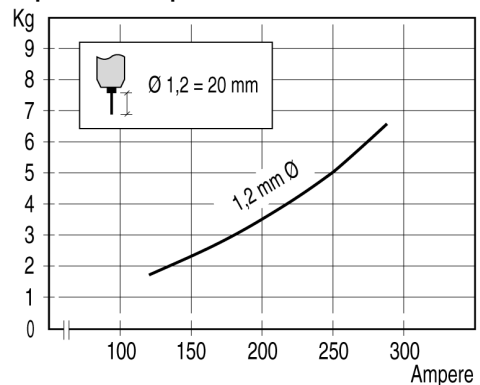
E309LCbT1-1/4

Approvals:

Recommended parameter range:



Deposition rate per hour:



Product data:

Diam.mm	Product code	Delivery form
1,2	95951012	15 kg PSP

Note

Cromacore DW 309LNb deposits a 347 type analysis in the weld metal in a single layer.