



# Shield-Bright 309L

FCAW

Shield-Bright 309L is an all-position flux cored wire for welding types 309 wrought, or cast forms, but used extensively for welding type 304 to mild or carbon steel. Also used for welding 304 clad sheets and for applying stainless steel sheet linings to carbon steel. Carbon content 0.04% maximum. Shield-Bright 309L is designed primarily for all position. Either pure CO<sub>2</sub> or mixed gas (75% Argon/25% CO<sub>2</sub>) can be used.

## Welding Current

DC (+)

## Shielding Gas

CO<sub>2</sub> or 75% Argon/25% CO<sub>2</sub>

PACKING/ORDERING INFORMATION			
Part Number	Dia (mm)	Carton Weight (kg)	Pallet Weight (kg)
VacPac			
35CA12248V	1.2	12.5	787.5
35CA16248V	1.6	12.5	787.5

CLASSIFICATIONS	APPROVALS	TYPICAL ALL WELD METAL COMPOSITION (%)			TYPICAL MECH. PROPERTIES ALL WELD METAL		
		Gas	CO <sub>2</sub>	75%Ar/25%CO <sub>2</sub>		As Welded CO <sub>2</sub>	As Welded 75%Ar/25%CO <sub>2</sub>
<u>SFA/AWS A5.22</u> E309LT1-1/E309LT1-4 <u>EN 12073</u> T23 12 L P C 2 T23 12 L P M 2	ABS E309LT1-1	C	0.029	0.029	Yield Stress, Mpa Tensile Strength, MPa Elongation, %	450	459
	LR SS/CMn S	Mn	1.1	1.3		580	389
	DNV 309L MS	Si	0.8	0.9		38	40
	NK KW309LG (C)	Cr	22.7	22.6			
	KR RW309LG (C)	Ni	12.5	12.6	Charpy V	Test temp, °C	Impact Values*
	BV 309L MS	FN	15	17		0	38

