



Shield-Bright 309L Xtra

FCAW

Shield-Bright 309L Xtra is designed for welding most mild steels or carbon steels to stainless steel in the flat and horizontal positions. The higher percentages for Cr and Ni provide the necessary crack resistance. Weld beads are finely rippled and horizontal fillets have an essentially flat surface and equal leg length. Either pure CO₂ or mixed gas (75% Argon/25% CO₂) can be used.

Welding Current

DC (+)

Shielding Gas

CO₂ or 75% Argon/25% CO₂

PACKING/ORDERING INFORMATION			
Part Number	Dia (mm)	Carton Weight (kg)	Pallet Weight (kg)
VacPac			
35CX12248V	1.2	12.5	787.5
35CX16248V	1.6	12.5	787.5

CLASSIFICATIONS	APPROVALS		TYPICAL ALL WELD			TYPICAL MECH. PROPERTIES			
			METAL COMPOSITION (%)			ALL WELD METAL			
<u>SFA/AWS A5.22</u> E309LT0-1/E309LT0-4 <u>EN 12073</u> T23 12 L R C 3 T23 12 L R M 3	ABS	E309LT0-1	Gas	CO ₂	75%Ar/25%CO ₂	Yield Stress, Mpa Tensile Strength, MPa Elongation, %	As Welded CO ₂	As Welded 75%Ar/25%CO ₂	
			C	0.031	0.027		453	473	
	Mn	1.5	1.6	579	592				
	Si	0.6	0.6	38	38				
				Cr	24.0	24.6	Charpy V	Test Temp, °C -100	Impact Values 24
				Ni	12.7	12.6			
				Mo	0.2	0.2			
				FN	19	21			

