

# ES FC 309LT

Type Rutile

FCAW

E309LT1-4

**ESWECO**  
*The Art of Welding*

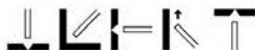
## Description

ES FC 309LT is a flux-cored, tubular wire which produces weld metal of the 309 type. While suitable for 25Cr12Ni type steels, the principal application is the vertical and overhead joining of dissimilar and difficult-to-weld steels. This includes the joining of clad steels to themselves and carbon-manganese steels.

Shielding gas  
Ar+20%CO<sub>2</sub>.

## Current

DC+



## Classifications

EN 12073	T 23 12 L P C 2, T 23 12 L P M 2
SFA/AWS A5.22	E309LT1-4

## Typical all weld metal composition, %

C	Si	Mn	Cr	Ni
0.034	0.9	1.3	22.6	12.6

## Typical mech. Properties all weld metal

Yield stress, MPa	459
Tensile strength, MPa	590
Elongation, %	37

## Welding parameters

Diameter, mm

1.2

Welding current, A

130-230

Arc voltage, V

26-31