

BW-309LP

Stainless Steel FCAW Wire

For 22% Cr-12%Ni Stainless Steel


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Specification: AWS A5.22: E309LT1-1/4

Applications & Features:

BW-309LP is suitable for welding of 22%Cr-12%Ni steel & heat resistant steel & dissimilar joint such as stainless steel to carbon steel or low alloy steel. Under layer welding on cladded side groove cladded stainless steel or carbon steel where stainless steel weld metal is overlaid.

Characteristics:

Provides excellent usability with stable arc, less spattering, good bead appearance, easy slag removal and less fume emission.

Superior mechanical properties.

Shielding gas is Argon+CO₂ or 100% CO₂.

Notes on Usage:

The optimum flow for shielding gas is 20-25l/min.

The distance between tip & base material is to be 15-25mm.

Protect the weld with a screen to prevent blowholes caused by wind where the wind velocity is 2m/sec & more.

Approvals:

ABS, BV, CWB, DNV, LR

Part Numbers:

P/N: 2112 (1.2mm 12.5kg spool)



Typical chemical composition of weld metal (%)

	C	Mn	Si	P	S	Cr	Ni	FN
BW-309LP	0.026	1.48	0.51	0.012	0.013	22.43	12.45	12

Typical mechanical properties of weld metal

	YP N/mm ² (MPa)	TS N/mm ² (MPa)	EL %	IV J (kgf-m)
				0°C
BW-309LP	542	605	39.6	50

Size & recommended current range (DC+)

Dia. mm (in)	Current(A)	Voltage(V)	Welding Speed(cm /min)
1.2(0.045)	150~300	24~33	20~60