FLUXINOX 309L PF

OERLIKON

MIG/MAG Cored Wires
Stainless and Heat resistant steels

FLUXINOX 309L-PF is an alloyed rutile flux cored wire for joining high-alloyed Cr and Cr-Ni-(Mo) steels to unalloyed steels, as well as for depositing austenitic stainless cladding. The highest operating temperature for dissimilar joints is 300 °C. The weld metal is non-scaling up to 850 °C. Preheating and interpass temperatures should be calculated according to the base metal used. FLUXINOX 309L-PF exhibits outstanding, almost spatter-free, welding properties and produces finely rippled flat and smooth welds which are free of undercut. Very easy slag removal. Due to its fast-freezing slag, FLUXINOX 309L-PF is used for welding in the horizontal (PD), overhead (PE) and vertical-up (PF) positions.

Classification	
EN ISO	17633-A: T 23 12 L P C 1
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EN ISO	17633-B: TS309L-FB1
EN ISO	A5.22: E309LT1-4
AWS	A5.22: E309LT1-1

Approvals	Grade
DNV	309L
GL	4332S
GL	4332S
LRS	SS/CMn
LRS	SS/CMn
TÜV	●
TÜV	●

CE

Chemical analysis (Typical values in %)

C	Mn	Si	Cr	Ni	Ferrite
≤ 0.04	0.7	0.6	24	13	10-20

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation	Impact Energy ISO - V (J)	
				20 °C	-60 °C
As Welded	≥ 320	≥ 520	≥ 30	≥ 40	≥ 27

Gas test: 82% Ar+18% CO2

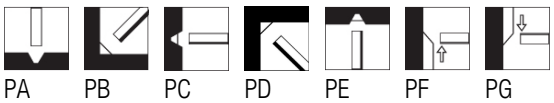
Shielding Gas - EN ISO 14175 : C1, M21

Materials

A312 TP309S; Ferrite-Austenite heterogeneous joints, Cladding

Storage
Keep dry and avoid condensation

Current condition and welding position
DC+



Packaging data

Packaging Type	BS300	S200
Diam(mm) / weight(kg)	15	5
1.0	●	
1.2	●	●