

**Standards**

TS EN ISO 17633-A	: T 23 12 L P M21/C1 1
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AWS A5.22	: E309L T1-1/-4

**Chemical Composition of  
Weld Metal (Typical)**

C	Si	Mn	Cr	Ni
0.03	0.70	1.40	23.5	13.0

**Mechanical Properties - (Typical):** (With M21 gas)

Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Impact Strength (ISO-V/-60°C)	Elongation ((L <sub>0</sub> =5d <sub>0</sub> ) (%))
460	580	40 J	35

**Typical Base Material Grades**

- High-strength unalloyed and heat-treatable steels, ferritic Cr and austenitic CrNi steels, austenitic Mn steels, unalloyed tempered steels, tool steels, hard manganese steels, ferritic chromium steels, austenitic nickel-chromium steels, hard-to-weld steels, similar-type austenitic steels, dissimilar metals, joining of corrosion resistant stainless steel with mild or low alloy steels, clad steels.

**Features and Applications**

- ELOXCOR S 309L is rutile fast freezing type flux cored wire
- Austenitic-ferritic deposit in over-alloyed CrNi steel type 309L, with optimised ferrite content for joining dissimilar metals
- Joining of steels with similar compositions and joining carbon steels to Stainless steels
- Buffering before cladding. Service temperatures from - 60°C to + 350°C
- Shielding Gas: CO<sub>2</sub> or M21

**Welding Positions**

**Current Type**

D.C (+)

**Operating Data**

Product Code	Diameter (mm) / (inch)		Weight (Kg)	Package Type
6011100256	1.20	0.047"	15	D 300

**Approvals:** ELOXCOR S 309 L (CO<sub>2</sub>): DNV-GL, SEPRO, CE