



MODI FC 309 LT FOR STAINLESS STEEL

CLASSIFICATION : AWS/A 5.22 : E 309L TS-1/-4

TYPICAL APPLICATIONS : Modi FC 308LT is designed for MAG welding of low carbon 22% Cr - 12% Ni stainless steels. Dissimilar joint welds, of and between high strength, mild steels and low alloyed QT-steels, stainless, ferritic Cr and austenitic **Cr-Ni** steels, manganese steels, cladding for the first layer of corrosion resistant weld claddings on ferritic- peritic steels in boiler and pressure vessel parts up to fine grained steel

CHARACTERISTICS :

1. Modi FC 309LT is a titania type of flux cored wire for all position welding.
2. The weld metal contain comparatively much more ferrite in their austenitic, therefore they provide better weldability together with superior heat resistance.
3. It is easy to use and operate with a powerful penetrating spray arc transfer, minimum spatter formation and self releasing slag.
4. The shielding gas should be used 100% CO₂ and 80% Ar + 20% CO₂ for welding.

CHEMICAL COMPOSITION OF WELD-METAL(%) :

C	Mn	Si	S	P	Cr	Ni	Mo	Cu
0.040	0.5-2.5	1.0	0.03	0.04	22.0-25.0	12.0-14.0	0.5	0.5
max		max	max	max			max	max

MECHANICAL PROPERTIES OF ALL WELD-METAL :

Ultimate Tensile Strength (min)	Elongation (%)
N/mm ² (Kg/mm ²)	(min)
520(53)	30

CURRENT CONDITIONS : Use DC (+)

SIZE (mm) : 1.2 1.6

AMPS : 100-220 160-260



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