

Cored Wires Stainless and Heat resistant steels

Fluxinox 309MoL-PF is an alloyed rutile flux cored wire mainly used for cladding. The highest operating temperature for dissimilar joints is 300°C and the weld metal is non-scaling up to 850 °C. Preheating and interpass temperatures should be calculated according to the base metal used. Fluxinox 309MoL-PF exhibits outstanding, almost spatter-free, welding properties. It produces finely rippled flat and smooth welds, free of undercut with very easy slag removal. Due to its fast-freezing slag, Fluxinox 309MoL-PF is used for welding in the horizontal (PD), overhead (PE) and vertical-up (PF) positions.

Classification	
AWS	A5.22: E309MoLT1-4 / E309MoLT1-1
EN	12073: T 23 12 2 L P M 1 / T 23 12 2 L P C 1

Approvals	Grades

Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Cu	N	Ferrite
≤ 0.04	1.50	0.70	-	-	24	13	2.50	-	-	-	12-20

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) + 20 °C	Hardness
As Welded	≥ 350	≥ 550	≥ 28	≥ 40	-

Gas test: Acc. To EN 439: M21(Arcal 21-Atal 6)

Shielding Gas: Acc. To EN 439: M21(Arcal21-Atal6) or C1(Arcal 2)

Materials

Cladding of carbon steel and low alloy steel

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+



PA PB PC PF PE

Packaging data: K300 kg, 16

Diameters	1,2					
-----------	-----	--	--	--	--	--