

COREMAX 309LP



Coremax 309LP is an all position flux cored wire for welding 24% Cr 13% Ni type austenitic stainless steels in the cast and wrought forms. It has excellent weldability and slag detachment and provides good resistance to intergranular corrosion. Coremax 309LP can also be used as a buffer layer prior to hardfacing and for joining 300 grade stainless steel to mild steels.

CLASSIFICATION

AWS A5.22 E309LT1-4

CHEMICAL ANALYSIS (TYPICAL)

% Carbon	0.030	% Phosphorous	0.020
% Manganese	1.70	% Chromium	24.20
% Silicon	0.59	% Nickel	10.43
% Sulphur	0.006		

**TYPICAL MECHANICAL PROPERTIES
(ALL WELD METAL IN THE AS WELDED
CONDITION)**

2% Proof Stress	450 MPa
Tensile Strength	568 MPa
Elongation on 5d	40%
Charpy V-Notch at -60°C	32J
Hardness HV	205

PACKING DATA

DC+

Position	Diameter (mm)	Amps	Volts	Item Number	Pack Mass (Kg)
F, HF	1.2	140 - 220	23 - 33	081-142	15
UV, OH		120 - 200	24 - 30		

Recommended Gas Afrox Flux Shield but can be used with 100% CO₂.

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