Unibraze 309LFCT

Flux Coated TIG

International Classifications: AWS A5.9/ASME SFA 5.9 ER309L EN 12072: W 23 12 L

Description: **Unibraze 309LFC** is a flux coated, low carbon, austenitic stainless steel TIG wire with a ferrite content suitable for welding dissimilar steels as well as stainless steel pipe in applications where a backing ring or a purge gas is required. It provides impurity free weldments, which is necessary during stainless steel pipe welding in the chemical and petrochemical industries. Flux Color: Yellow

Welding Techniques: Clean weld surface carefully to remove all scale and corrosion. Sections over 3mm should be beveled to permit complete penetration. Clean joint surface using a stainless steel brush. Use DC- (straight polarity), 2% thoriated tungsten electrode. Welding positions: Flat, Horizontal, Vertical up.

Typical Chemical Analysis (All weld metal%)

C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Fe	FN*
.015	19	.40	.01	.02	23.2	13.8	.10	.08	Bal	6

**FN Range 3-9*

Typical Mechanical Properties (Undiluted Weld Metal)

Tensile Strength	90,000 psi (620 MPa)
Yield Strength	66,000 psi (420 MPa)
Elongation	42%
Impact Energy	40J: -157°F (-105°C
Hardness	Brinell 209, Rockwell B96

Amperage Recommendations (DC- Straight Polarity)

Diameter	Amps
3/32”	60-100
1/8”	80-120

Typical Deposition Rates

Diameter	Length	Weldmetal	Rod per lb of Weldmetal	Arc Time of Deposition min/lb	Amperage Setting	Recovery Rate
3/32”	18”	1.5 oz.	10	21	80	100%
1/8”	18”	2.0 oz.	8	18	100	100%

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