

# CLEARINOX F 309L PF

## TOP FEATURES

- Reduced welders' exposure to welding fumes
- High alloyed rutile flux cored wire with fast freezing slag for welding of dissimilar joints, buffer layers or cladding.
- Reduced welding fume (up to -40%).
- Reduced emission of hexavalent Cr content (up to -60%).
- Easy slag removal.

## CLASSIFICATION

AWS A 5.22	E309LT1-1
	E309LT1-4
EN ISO 17633-A	T 23 12 L P M21 1
	T 23 12 L P C1 1
EN ISO 17633-B	TS309L-FB1

## CURRENT TYPE

DC+

## WELDING POSITIONS

All positions

## SHIELDING GASES (ACC. EN ISO 14175)

M21 Mixed gas Ar+ >15-25% CO<sub>2</sub>

## APPROVALS

LR	BV	DNV	TÜV
+	+	+	+

## CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Si	Cr	Ni	Ferrite
≤0.04	0.7	0.6	24	13	10-20

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)	
						-20 °C	-60 °C
Typical values	M21	AW	≥320	≥520	≥30	≥40	≥27

\* AW = As welded

Gas test: 82% Ar + 18% CO<sub>2</sub>

## PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.2	SPOOL (S200)	5.0	W001387176

## TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing.  
Please refer to [www.lincolnelectric.eu](http://www.lincolnelectric.eu) for any updated information.