

GFC 309

IDENTIFICATION

GFC 309, E309T-1/4

CLASSIFICATION

AWS A5.22 E309T-1/4 JIS Z3323 YF 309LC

DESCRIPTION

GFC 309 (for all-position operation) is used to join similar 309 alloy or join 300 series stainless steel to carbon or low alloy steels. It is also recommended for use as the first layer in a single or multilayer surfacing of non-alloy and low-alloy steels to give a 304L deposit. Manufactured under a quality system certified to ISO:9001 requirements.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	P	S	Cr	Ni	Mo	Cu
0.10 max	0.5 - 2.5	1.0 max	0.04 max	0.030 max	22 - 25	12-14	0.50 max	0.50 max

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	EL (%) (L=4D)
560 min	30 min

TYPICAL APPLICATIONS

Used for welding similar alloys in wrought or cast form; to weld type 304 base metals when severe corrosion conditions exist; and welding dissimilar steels.

CHARACTERISTICS ON USAGE:

Generally used with 100% CO2 shielding gas or mixtures of Ar + 20-25% CO2. Stable arc transfer and ideal

slag removal guarantee that slag comes off easily, creating a smooth and fine bead surface.

PACKING PARAMETERS

Size (mm)	Fillet (HF)		Voltage (OH)		Weight / Spool (kg)
	AMPS DC (+)	VOLTAGE (V)	AMPS DC (+)	VOLTAGE (V)	
1.2	140 - 240	23 - 33	120 - 200	24 - 30	12.5
1.6	200 - 300	27 - 32	Not Recommended		12.5