



LSF30 x LSW-309/309L

LINKWELD ALLOYS INC.

AWS A5.9 ER309/309L
JIS Z3324 S309/309L

Characteristics:

LSF-30 is an agglomerated flux adding proper contents of alloying element to maintain the stability of the contents of ferrite in weld metal. It is designed for welding with stainless steel 309/309L to gain characteristics of great crack and corrosion resistibility and mechanical property. With good weldability, slag removal, stable arc, smooth bead appearance and welding efficiency.

Applications:

It is suitable for welding of stainless steel 309/309L.

Notes on Usage:

1. Dry the flux at 300-350°C for 60 minutes before use.
2. To get the corrosion resistibility and mechanical properties on heat effect zone, recommend to use low heat input.

Typical chemical composition of weld metal (wt%)

C	Mn	Si	Ni	Cr
0.03	1.48	0.62	13.32	23.25

Typical mechanical properties of weld metal

TS N/mm ²	EL%	IV -196°C J
567	41	-

Sizes available, Package:

Wire: Diameter (mm)	2.4	3.2	4.0
Wire: Weight per roll (kg)	25	25	25
Flux: Weight per bag(kg)	25	25	25