

E309LT1-1

Conformance

AWS A5.22 E309LT1-1

Typical Application

• Used for welding some key structures like shipbuilding, mechanical manufacture, petroleum machinery, chemical machinery, hoisting machinery etc

Mechanical Properties

Tensile Strength (MPa)	Yield Strength (MPa)	Elongation (%)	Impact Energy (J)	Impact Temperature (°C)
545	480	29	77, 95, 83	-20

Chemical Composition %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu
0.021	1.68	0.58	0.003	0.018	12.39	23.82	0.08	0.07

Reference

Shielding Gas	CO ₂	
Gas Flow Rate (L/min)	20~25	
Diameter (mm)	1.2	1.6
Current(A) DC ⁺	160~240	180~270