



Supplier of Welding Alloys

Stainless Steel Flux Cored Wire

Oxford Alloy® 309LT-1

SPECIFICATIONS

AWS 5.22
ASME SFA 5.22

CLASSIFICATIONS

AWS E309LT1-1/T1-4
UNS W30935

DESCRIPTION / APPLICATION

Oxford Alloy E309LT1-1/T1-4 is designed for welding type 309 wrought, or cast forms, but used extensively for welding type 304 to mild or carbon steel. This flux cored wire is also for welding 304 clad sheets and for applying stainless steel sheet linings to carbon steel. Maximum carbon content allowed is 0.04%. Oxford Alloy E309LT1-1/T1-4 was developed for out-of-position welding. This flux cored wire will deposit out-of-position welds at substantially higher welding currents than other stainless steel flux cored wires, resulting in a higher deposition rate. The slag is self-peeling and minimizes cleanup. Oxford Alloy E309LT1-1/T1-4 was formulated for use with 75% Argon/25% CO² shielding gas; however, straight CO² may also be used. The 75/25 mixture will produce a smooth arc with virtually no spatter and slightly higher yield and tensile strengths than CO². The mechanical properties and deposit analysis will meet AWS 5.22 specifications with either gas.

AWS Chemical Composition						
C	Mn	Si	Cr	Ni	Mo	P
0.04 max	0.5-2.5	1.0 max	22.0-25.0	12.0-14.0	0.5 max	0.04 max
S	Cu					
0.03 max	0.5 max					

TYPICAL MECHANICAL PROPERTIES

Tensile strength: 84,100 psi 580 MPa

Yield strength: 65,250 psi 450 MPa

Elongation: 37%

Please contact our sales department for more information at 800-562-3355 or 225-273-4800.

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