



**Changzhou Giant Welding Co.,Ltd**  
www.giantweld.com

Standard : AWS A5.22 E309LT1-1	Chemical Composition    %								
	C	M n	Si	Ni	Cr	Mo	Cu	S	P
Grade E309LT1-1	≤ 0.04	0.5 ~ 2.5	≤ 1.0	12.0 ~ 14.0	22.0 ~ 25.0	≤0.50		≤0.03	≤ 0.04
Type	Spool (MIG)								
Specification ( MM )	0.8、 0.9、 1.0、 1.2、 1.6			Pack	S100/1kg   S200/5kg   S270,S300/12.5kg-20kg				
Mechanical Properties	Rm / MPa				A (%)				
	≥ 520				≥ 35				
MIG Welding	(MM)	1.2			1.6				
	Current - A	120 ~ 250			160 ~ 300				
Application	<div><div>•    <b>Welding Dissimilar Metals:</b> It's widely used for joining stainless steels to carbon steels or low alloy steels, which is a common requirement in many industrial fabrication and repair scenarios.</div><div>•    <b>Cladding and Overlay Applications:</b> It serves as a buffer layer for cladding mild steel or low alloy steel with stainless steel, or for the initial passes in multi-layer overlays, to provide a corrosion-resistant and often heat-resistant surface.</div><div>•    <b>Fabrication of Stainless Steel Structures:</b> Used for welding type 309 stainless steel structures, as well as for general fabrication of equipment in industries such as petrochemical, power generation, and food processing, where good corrosion resistance and all-position weldability are needed.</div></div>								

