

WELDERS'
FAVOURITE
SINCE 1938

CROMACORE
Stainless steel flux-cored wires

Flux cored wires for flat and horizontal welding

Features

- Good single and multilayer weldability
- Intensive arc and deep penetration



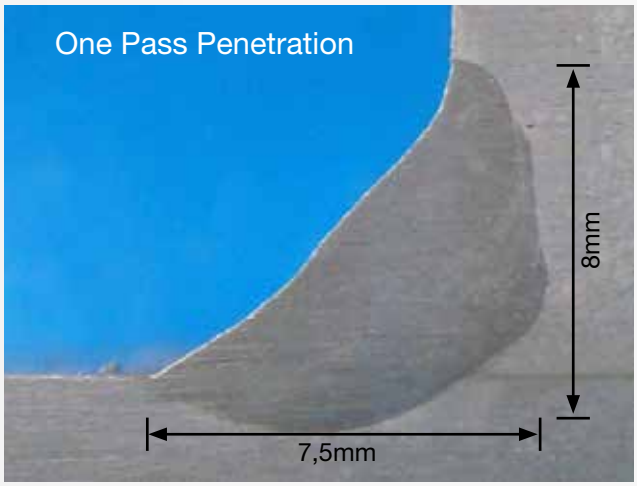
Single layer bead appearance

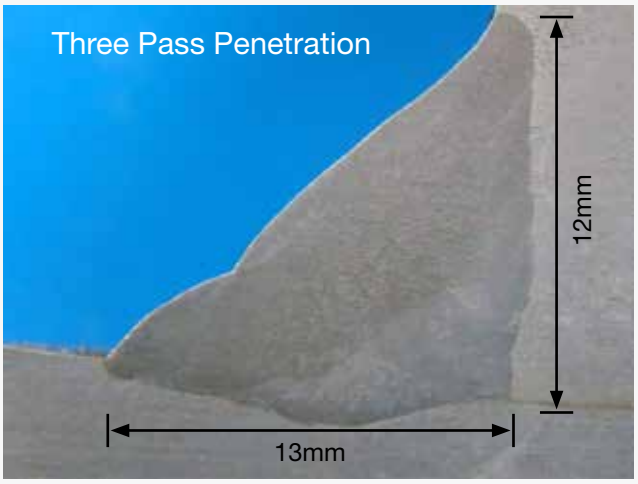
Notes on usage

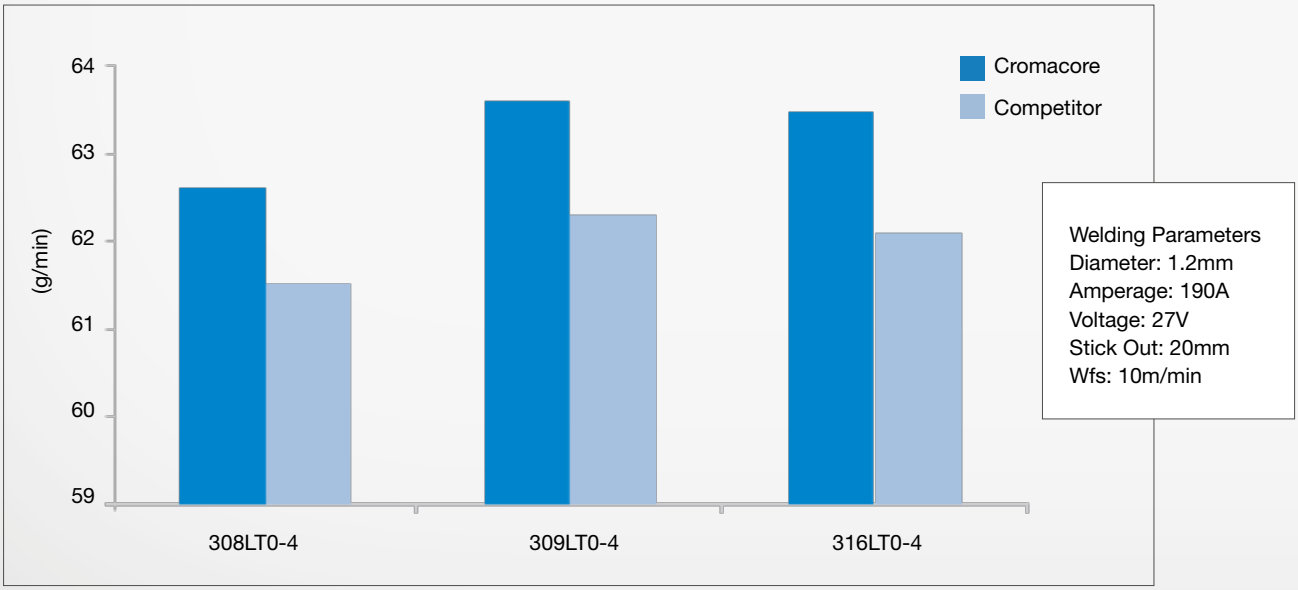
- Recommended for use with mixed gas (80% Ar/20% CO_2)
- Before welding, the base metal should be cleaned to remove oil, rust and moisture, and should be protected from the wind while welding.
- For flat and horizontal position



Multi-layer bead appearance







Product description

Product Information

Product	EN ISO 17633-A Classification	AWS A5.22 Classification	Diameter	Packaging	Applications	Item Number
Cromacore 308LT0-4	T 19 9 L R M21 3	E308LT0-4	1.2mm	15 kg Spool/WBS	Pipe Process Pressure Vessel	9470-1012
Cromacore 309LT0-4	T 23 12 L R M21 3	E309LT0-4	1.2mm	15 kg Spool/WBS	Dissimilar Joint (CS/SS)	9472-1012
Cromacore 316LT0-4	T 19 12 3 L R M21 3	E316LT0-4	1.2mm	15 kg Spool/WBS	Pipe Process Pressure Vessel	9471-1012

Available also on 5kg spools (XXXX-2112)
All spools are precision layer wound

Typical chemical composition of weld metal (wt%)

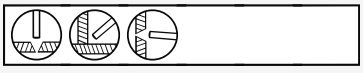
Product	C	Si	Mn	P	S	Ni	Cr	Mo	FN*
Cromacore 308LT0-4	0.027	0.56	1.6	0.027	0.009	9.9	19.5	0.02	10
Cromacore 309LT0-4	0.026	0.66	1.5	0.025	0.009	12.5	24.1	0.02	20
Cromacore 316LT0-4	0.023	0.81	1.5	0.025	0.011	12.2	18.6	2.79	9

* by WRC1992

Typical mechanical properties of weld metal

Product	YS (Mpa)	TS (Mpa)	EL (%)	CVN (-20˚C) J
Cromacore 308LT0-4	420	592	38	54
Cromacore 309LT0-4	428	559	33	42
Cromacore 316LT0-4	467	601	37	43

Welding positions



Recommended current range (DCEP)

Welding position	Parameter Range (A/V)
F, HF (1F, 1G)	150-210A/26-28V
H (2F, 2G)	180-190A/24-28V

Approvals

See www.elga.se for valid approvals.

Flux cored wires for all position welding

Features

- Designed for hot, fill and cap pass for pipe welding.
- Excellent bead appearance on pipe.
- Superb slag removal



Single layer bead appearance

Notes on usage

- Recommended for use with mixed gas (80% Ar/20% CO_2)
- Before welding, the base metal should be cleaned to remove oil, rust and moisture, and should be protected from the wind while welding.
- For all position

6-7 o'clock
(overhead position)



8-9 o'clock
(overhead-vertical position)



9-10 o'clock
(vertical position)



Bead appearance on pipe welding at different positions

Product description

Product Information

Product	EN ISO 17633-A Classification	AWS A5.22 Classification	Diameter	Packaging	Applications	Item Number
Cromacore 308LT1-4	T 19 9 L P M21 1	E308LT1-4	1.2mm	15 kg Spool/WBS	Pipe Process Pressure Vessel	9477-1012
Cromacore 309LT1-4	T 23 12 L P M21 1	E309LT1-4	1.2mm	15 kg Spool/WBS	Dissimilar Joint (CS/SS)	9475-1012
Cromacore 316LT1-4	T 19 12 3 L P M21 1	E316LT1-4	1.2mm	15 kg Spool/WBS	Pipe Process Pressure Vessel	9474-1012
Cromacore 309MoLT1	T 23 12 2 L P M21 1	E309LMoT1-4	1,2mm	15 kg Spool/ WBS	Dissimilar Joint (CS/SS), Buffer Layers	9485-1012
Cromacore 2209T1	T 22 9 3 N L P M21 1	E2209T1-4	1,2mm	15 kg Spool/ WBS	Duplex Steels	9478-1012

Available also on 5kg spools (XXXX-2112). All spools are precision layer wound.

Typical chemical composition of weld metal (wt%)

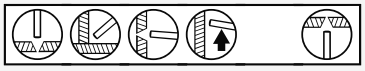
Product	C	Si	Mn	P	S	Ni	Cr	Mo	FN*
Cromacore 308LT1-4	0.029	0.62	1.7	0.025	0.007	10.2	18.6	0.16	6
Cromacore 309LT1-4	0.026	0.65	1.6	0.027	0.007	13.8	23.7	0.14	14
Cromacore 316LT1-4	0.028	0.62	1.2	0.032	0.007	12.3	18.1	2.55	5
Cromacore 309MoLT1	0,02	0,62	1,5	0,023	0,010	13,7	22,7	2,2	18
Cromacore 2209T1	0,027	0,50	0,97	0,027	0,007	9,0	22,2	3,2	37

* by WRC1992

Typical mechanical properties of weld metal

Product	YS (Mpa)	TS (Mpa)	EL (%)	CVN (0°C) J	CVN (-20°C) J	CVN (-46°C) J
Cromacore 308LT1-4	415	568	42		62	
Cromacore 309LT1-4	458	587	35		55	
Cromacore 316LT1-4	435	583	40		63	
Cromacore 309MoLT1	560	730	26	40		
Cromacore 2209T1	715	830	27			42

Welding positions



Recommended current range (DCEP)

Welding position	Parameter Range (A/V)
F, HF (1G, 1F)	130-220A/24-33V
H (2G, 2F)	140-180A/25-29V
V-up (3G, 3F)	130-180A/24-29V
OH (4G, 4F)	150-180A/25-29V

Approvals

See www.elga.se for valid approvals.

Notes

Please contact your local ITW sales office for more information.

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