

**Specifications:**

E309LT1-1, E309LT1-4  
 AWS A5.22  
 ASME SFA 5.22  
 UNS W30935

**Properties (min.):**

**Tensile Strength:** 75,000 psi  
**Elongation:** 30%

**Description:**

WT 309L-T1 is a gas-shielded and flux-cored stainless steel. It contains a low carbon content to reduce carbide precipitation and a higher resistance to intergranular corrosion without the stabilizers, such as Nb and Ti. The lower carbon is not as strong at higher temperatures. 309L-T1 is used to weld 309 stainless, dissimilar welds between carbon or low alloy steels to austenitic stainless steels as well as the first layer cladding of carbon steel if no Nb additions are required.

**Chemical Composition (Wt%)**

C	Cr	Ni	Mo	Mn	Si	P	S	Cu
.04	22.0-25.0	12.0-14.0	.75	.50-2.5	1.0	.04	.03	.75

Note: Single values are maximum unless otherwise noted.

**Maintaining a proper welding procedure, including pre-heat and interpass temperatures, may be critical depending on the type and thickness of material being welded.**

**CAUTION:** Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standards A49.1, "Safety in Welding and Cutting," published by the American Welding Society, 8669 NW 36 Street, #130, Miami, FL 33126: OSHA Safety and Health Standards 29 CFR 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210.