

Product group: **090**    Product number: **309001**

Wire for GMAW welding of stainless steel to mild steel, compound steel and stainless steel overlays.



### Product information

This product supersedes product no: **309000**

Unitor S 309 M-GF 222 is a rutile flux cored wire designed for welding of clad steel (compound steel), stainless steel, mild steel and corrosion resistant overlays on mild steel. It can also be used for welding of stainless steel with chemical composition of up to 23% Cr, 13% Ni, and 2.3% Mo.

### Features

- Application include welding of stainless steel 309L, mild steel to stainless steel and clad steel
- No granulation of crystals up to 350oC, no oxidation below 800oC working temperature

### Benefits

- High productivity welding as the wire operates with a very stable, spatter free arc producing a bright, smooth weld bead surface and easy slag removal

### Specification

#### General

Invent Hazard Material (IMO/EU) classification	NA
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#### Dimensions/Weight

Diameter [mm]	0.9
Weight [kg]	2.5

#### Technical data

AWS	A5.22: E309NbT0-4(1)
Polarity	DC+
Voltage [V]	24
Wire Speed [m/min]	13

### Documents

[SDoC and MD for IHM](#)

### Directions for use

Use 80%/20% Ar/CO2 (UNIMIX) preferably as shielding gas

### Related products

#### Is frequently bought together with

**301301**  
UWW-301 TP WIRE WELDER

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