

# Cored Wires

## Mild Steel Metal Cored Wire

### Corofil 20/9/3

SFA/AWS A5.22.95 E308L Mo T0-4

#### Description and applications

Corofil 20/9/3 is a rutile stainless flux-cored wire designed for welding hardenable steels and dissimilar steel combinations. The 1.2mm diameter wire is intended for positional welding applications, and the 1.6mm diameter for higher deposition rate downhand welding. The wire is intended for applications such as welding armour plate. It is also recommended for joining hardenable low alloy, high tensile strength steels, spring steels and other 'difficult to weld' steels. The use of Corofil 20/9/3 may allow a reduction in the preheat needed to weld certain hardenable steels.

#### Approvals

**(May Vary with gas)**

MOD: DEF STAN 34-7 : 2Ab, 2B

#### Typical all-weld mechanical properties under shielding gas of 80 Ar/20 CO<sub>2</sub>

##### Composition Wt %

	Min	Max
C		0.04
Si		1.0
Mn	0.50	2.50
S		0.03
P		0.04
Cr	18.0	21.0
Ni	9.0	12.0
Mo	2.0	3.0
Cu		0.50

##### Mechanical Properties of Weld Metal

Properties	All Weld Metal (%)	
	Min	Typ
	M21 shielding gas	
	As Welded	
Rm (MPa)	520	
A4-A5 (%)	35	40

##### Current range

DC + with shielding gas of 15-25 l/min Ar/20%CO<sub>2</sub> or CO<sub>2</sub>

Size (mm)	1.2	1.6
Current (amps)	150-300	200-350