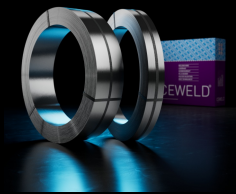




CEWELD SA 309LMo

TYPE	Stainless steel solid wire								
APPLICATIONS	Cladding tanks, vessels, tubes etc. Welding dissimilar materials like carbon steel to stainless steels								
PROPRIÉTÉS	SA 309LMo is a solid wire for SAW which operates with very stable, spatter free arcs. This wire deposits low carbon weld metal of about 23%Cr-13%Ni-2.3%Mo. Cladding on low alloyed steels in case a 18/8/2 CrNiMo layer is required in the first layer.								
CLASSIFICATION	AWS	A 5.9: ER309LMo							
	EN ISO	14343-A: S 23 12 2 L							
	W.Nr.	1.4459							
	F-nr	5							
	FM	6							
CONVIENT POUR	ISO 15608: 8.1 Austenitic ≤ 19 % Cr , TÜV 1000: Gr. 21-30, 1.4583, 1.4435, 1.4436, 1.4404, 1.4406, 1.4408, 1.4401, 1.4571, 1.4580, 1.4406, 1.4521, 1.4301, 1.4306, X102CrNiMoNb 18 12, X2CrNiMo 18 14 3 (TP), X4CrNiMo 17 13 3, X2CrNiMo 17 12 2 (TP), X 5CrNiMo 19 11 2, X4CrNiMo 17 12 2 (TP), X6CrNiMo 17 12 2, X6CrNiMoNb 17 12 3, X2CrNiMoN 17 12 3 (TP), X2CrMoTi18-2 316Cb, 316L, 316L, 316LN, 316H, 316, 316Ti, 316Cb, 316LN, 444 S31640, S31603, S31653, S31600, S31630, S44400								
AGRÉMENTS	CE								
POSITIONS DE SOUDAGE	PAPBPC								
ANALYSE CHIMIQUE TYPIQUE DU MÉTAL D'APPORT (%)	C	Si	Mn	P	S	Cr	Ni	Mo	Cu
	0.015	0.4	1.8	0.015	0.01	24	13.5	2.6	0.12
PROPRIÉTÉS MÉCANIQUES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A5 (%)	Impact Energy (J) ISO-V			Hardness	
					RT				
	As Welded	370	540	32	60			HRc	
ETUVAGE	Not required								
GAS ACC. EN ISO 14175									



CEWELD SA 309LMo

SA 309LMO 2,0MM

Packaging	KG/unit	EanCode
K-415	25	8720663414267

SA 309LMO 2,4MM

Packaging	KG/unit	EanCode
K-415	25	8720663414274