



# CEWELD AA 309 LNb

**TYPE** Rutile flux cored stainless steel welding wire with exceptional Weldability for use with M21 and Co2. (Type 23 12 Nb, 1.4556)

**APPLICATIONS** Cladding mild and low alloyed steels in offshore and or chemical plants in case AISI 347 or AISI 321 are required as clad layer

**PROPERTIES** Smooth drop transfer and stable arc with no spatter losses. Excellent productivity and weldability, better wetting properties compared to solid wires. Excellent weld metal quality and X-ray soundness and excellent slag removal. Excellent for use in position and down hand as well. High resistance against moisture pick up

**CLASSIFICATION**

AWS	A 5.22: E309LNbT0-1
EN ISO	17633-A: TZ 23 12 L Nb R M21 1
W.Nr.	1.4556
F-nr	6
FM	5

**SUITABLE FOR** **Type 23 12 Nb, E309LNb TÜV Groupe 29 (+22+21)**  
 1.4878, 1.4825, 1.4541, 1.4550, 1.4552 1.4319, 1.4306, 1.4306, 1.4301, 1.4303, 1.4308, 1.4310, 1.4312  
 X 12 CrNiTi 18 9, G-X 25 CrNiSi 27 4, X 6 NiTi 18 10, X 6CrNiNb 18 10, G-X 5CrNiNb 18 9, X 5CrNi 18 7, X 2CrNi 19 11, G-X 2CrNi 18 9, X 5CrNi 18 10, X 5CrNi 18 12 G-X, 6CrNi 18 9, X 12CrNi 17 7, G-X 10CrNi 18 8  
 Cr - CrNi(Mo)- S355

**APPROVALS** CE

**WELDING POSITIONS**

**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

C	Si	Mn	P	Cr	Ni	Nb+Ta	S	FN	FS	FNW
0.03	0.7	1.4	0.02	23	12.5	0.8	0.08	18	16	25

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>P0.2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness
				RT	0°C	
As Welded	480	650	35	80	70	HRc

**REDRYING** 140°C / 24 hr

**GAS ACC. EN ISO 14175** M21, C1