




# CEWELD SA 308L strip

TYPE	Stainless steel strip for ESW																
APPLICATIONS	Cladding surfaces																
PROPRIÉTÉS	Strip with 19Cr/9Ni composition, ESW process has very low dilution so in the first layer you almost reach the chemical composition. Flux FL 860 ESH can be used.																
CLASSIFICATION	AWS A 5.9: EQ308L EN ISO 14343-A: B 19 9 L FM 1.4316																
CONVIENT POUR	<b>ISO 15608: 8.1 Austenitic <math>\leq</math> 19 % Cr 9% Ni, TÜV 1000: Gr. 21 - 22 (29 max.350°C),</b> 1.4301, 1.4306, 1.4307, 1.4308, 1.4311, 1.4312, 1.6900, 1.6901, 1.6902, 1.6903, 1.9606, 1.4541, 1.4546, 1.4550 X 5 CrNi 18 10, X 2 CrNi 19 11, X 5 CrNi 18 9, G-X 6 CrNi 18 9, X 12 CrNi 18 9, G-X 8 CrNi 18 10, X 6 CrNi 18 10, X 10 CrNiTi 18 10, X 5 CrNi 18 10 AISI 304, 304H, 312, 321H, 347, 347H, UNS S30409, S32109, S34709, S30400, S32100, S34700																
AGRÉMENTS	CE																
POSITIONS DE SOUDAGE																	
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table><thead><tr><th>C</th><th>Si</th><th>Mn</th><th>P</th><th>S</th><th>Cr</th><th>Ni</th><th>Mo</th></tr></thead><tbody><tr><td>0.02</td><td>0.55</td><td>2</td><td>0.02</td><td>0.01</td><td>21</td><td>10</td><td>0.5</td></tr></tbody></table>	C	Si	Mn	P	S	Cr	Ni	Mo	0.02	0.55	2	0.02	0.01	21	10	0.5
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PROPRIÉTÉS MÉCANIQUES	<table><thead><tr><th>Heat Treatment</th><th>R<sub>p0,2</sub> (MPa)</th><th>R<sub>m</sub> (MPa)</th><th>A5 (%)</th><th>Hardness</th></tr></thead><tbody><tr><td>As Welded</td><td>450</td><td>600</td><td>&gt;35</td><td>HRc</td></tr></tbody></table>	Heat Treatment	R <sub>p0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A5 (%)	Hardness	As Welded	450	600	>35	HRc						
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As Welded	450	600	>35	HRc													
ETUVAGE	Not required																
GAS ACC. EN ISO 14175																	