

CEWELD SA 309L

TYPE Solid drawn stainless steel welding wire for SAW welding

APPLICATIONS Buffer layers before hard facing, dissimilar joints between ferritic and austenitic steels and or difficult to weld steels.

PROPRIÉTÉS High mechanical properties and very good weldability due to a increased silicon content, suitable for operating temperatures up to 300°C. Flux FL 838 of fused flux FL 880

CLASSIFICATION

AWS	A 5.9: ER309
EN ISO	14343-A: S 23 12 L
W.Nr.	1.4332
F-nr	6
FM	5

CONVIENT POUR ISO 15608: 8.1 Austenitic ≤ 19 % Cr , TÜV 1000: Gr. 21-30, 23% Cr, 12%Ni Type
 1.2780, 1.4541, 1.4550, **1.4710, 1.4712, 1.4713, 1.4724, 1.4729, 1.4740, 1.4741, 1.4742, 1.4746, 1.4762, 1.4745, 1.4825, 1.4826, 1.4828, 1.4832, 1.4878,**
 X15CrNiSi20 12, G-X 40 CrNiSi20 9,
 AISI 446, AISI442, AISI309,
 UNS S30900, S44200, S44600

AGRÉMENTS CE

POSITIONS DE SOUDAGE

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

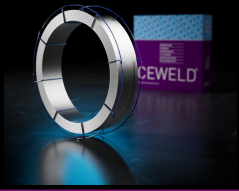
C	Si	Mn	P	S	Cr	Ni	Mo
0.02	0.55	2	0.02	0.02	24	13	0.2

PROPRIÉTÉS MÉCANIQUES

Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
				RT		
As Welded	370	570	33	100		HRc

ETUVAGE Not required

GAS ACC. EN ISO 14175



CEWELD SA 309L

SA 309L 2,0MM

Packaging	KG/unit	EanCode
K-415	25	8720663414151

SA 309L 2,4MM

Packaging	KG/unit	EanCode
K-415	25	8720663414144

SA 309L 3,2MM

Packaging	KG/unit	EanCode
K-415	25	8720663414120

SA 309L 4,0MM

Packaging	KG/unit	EanCode
K-415	25	8720663414137