




CEWELD SA 308L strip

TYPE	Stainless steel strip for ESW																	
TOEPASSINGEN	Cladding surfaces																	
EIGENSCHAPPEN	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.																	
CLASSIFICATIE	AWS	A 5.9: EQ308L																
	EN ISO	14343-A: B 19 9 L																
	FM	1.4316																
GESCHIKT VOOR	<p>ISO 15608: 8.1 Austenitic ≤ 19 % Cr 9% Ni, TÜV 1000: Gr. 21 - 22 (29 max.350°C), 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</p>																	
GOEDKEURINGEN	CE																	
LASPOSITIES																		
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1"> <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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MECHANISCHE WAARDEN	<table border="1"> <thead> <tr> <th>Heat Treatment</th> <th>R_{p0,2} (MPa)</th> <th>R_m (MPa)</th> <th>A5 (%)</th> <th>Hardness</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td>450</td> <td>600</td> <td>>35</td> <td>HRc</td> </tr> </tbody> </table>		Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A5 (%)	Hardness	As Welded	450	600	>35	HRc						
Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A5 (%)	Hardness														
As Welded	450	600	>35	HRc														
HERDROGEN	Not required																	
GAS ACC. EN ISO 14175																		