



# CEWELD SA 309L

**TYPE** Solid drawn stainless steel welding wire for SAW welding

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

**EIGENSCHAPPEN** 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

**CLASSIFICATIE**

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

**GESCHIKT VOOR** **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

**GOEDKEURINGEN** CE

**LASPOSITIES**



**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

**MECHANISCHE WAARDEN**

Heat Treatment	R <sub>P0.2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness
				RT		
As Welded	370	570	33	100		HRc

**HERDROGEN** 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