



# CEWELD 309LMo

**TYPE** Solid stainless steel wire for dissimilar welding and cladding.

**TOEPASSINGEN** A continuous, solid, corrosion-resistant wire of the "309LMo" type. 309MoL is used for the overlay welding of unalloyed and low-alloyed steels and for welding dissimilar steels, such as 316L, to unalloyed and low-alloyed steels when Mo is essential.

**EIGENSCHAPPEN** Excellent corrosion resistance against oxidizing air up to 950°C. Good resistance against hot cracking due to the high Mo. content.

**CLASSIFICATIE**

AWS	A 5.9: ER309LMo
EN ISO	14343-A: G 23 12 2 L
W.Nr.	1.4459
F-nr	6
FM	5

**GESCHIKT VOOR** **ISO 15608: 8.1 Austenitic ≤ 19 % Cr , TÜV 1000: Gr. 21-30,**  
 1.4583, 1.4435, 1.4436, 1.4404, 1.4406, 1.4408, 1.4401, 1.4571, 1.4580, 1.4406, 1.4521, 1.4301, 1.4306,  
 X102CrNiMoNb 18 12, X2CrNiMo 18 14 3 (TP), X4CrNiMo 17 13 3, X2CrNiMo 17 12 2 (TP), X 5CrNiMo 19 11 2, X4CrNiMo 17 12 2 (TP), X6CrNiMo 17 12 2, X6CrNiMoNb 17 12 3, X2CrNiMoN 17 12 3 (TP), X2CrMoTi18-2  
 316Cb, 316L, 316L, 316LN, 316H, 316, 316Ti, 316Cb, 316LN, 444  
 S31640, S31603, S31653, S31600, S31630, S44400

**GOEDKEURINGEN** CE

**LASPOSITIES**

**TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)**

C	Si	Mn	Cr	Ni	Mo
0.02	0.5	1.4	24	13	2.5

**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	-40°C	
As Welded	400	600	31	110	60	HRc

**HERDROGEN** Not required

**GAS ACC. EN ISO 14175** M13, M12



# CEWELD 309LMo

## 309LMO 0,8MM

Packaging	KG/unit	EanCode
BS-300	15	8720663414106
D-100	1	8720663414113

## 309LMO 1,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720663414168

## 309LMO 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663414175