CEWELD 309LMo Tig

certilas® THE FILLER METAL SPECIALIST

TYPE

Stainless steel Tig welding wire for dissimilar welding and cladding.(Typ 309LMo, 23 12 2 L, 1.4459)

APPLICATIONS

A continuous, solid, corrosion-resistant wire of the "309LMo" type. CEWELD 309LMo 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. Buffer layers before hard facing, dissimilar joints between ferritic and austenitic steels and or other stainless steel types to standard carbon steel. Recommended for cladding on low alloyed steel in case AISI 316 is required as first layer.

PROPERTIES

Excelent corrosion resistance against oxidising air upto 950°C. Good resistance against hot cracking due to the high Mo content. During build-up welding, the weld metal already achieves approximately the composition of ASTM 316 in the 1st layer.

CLASSIFICATION

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

SUITABLE FOR

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

APPROVALS

CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	P	S	Cr	Ni	Mo	FN
0.02	0.5	1.8	0.012	0.01	24	13	2.5	9

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
				RT	-40°C	
As Welded	400	600	31	110	60	HRc

REDRYING

Not required

GAS ACC. EN ISO 14175

I1

CEWELD 309LMo Tig

309LMO TIG 1,6 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663414199

309LMO TIG 2,0 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663414205

309LMO TIG 2,4 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663414212

309LMO TIG 3,2 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663414830

309LMO TIG 4,0 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663414847