




CEWELD AA 309 LMo

TYPE	Rutile flux cored weldig wire for M21 and C02. (Type 1.4459, 23 12 2)																						
APPLICATIONS	Cladding applications in case a AISI 316 is required in the first layer, suitable for dissimilar welding of steel to stainless steel, heat resistant up to 1050 degrees Celsius.																						
PROPERTIES	CEWELD AA 309 LMo is a rutile flux cored wire which operates with very stable, spatter free arc producing bright, smooth weld bead surfaces and self releasing slag. This wire deposits low carbon weld metal of about 23%Cr-13%Ni-2.3%Mo																						
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.22: E309LMoT0-1</td> </tr> <tr> <td>EN ISO</td> <td>17633-A: T 23 12 2 L R M21 3</td> </tr> <tr> <td>W.Nr.</td> <td>1.4459</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>5</td> </tr> </table>	AWS	A 5.22: E309LMoT0-1	EN ISO	17633-A: T 23 12 2 L R M21 3	W.Nr.	1.4459	F-nr	6	FM	5												
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SUITABLE FOR	<p>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</p>																						
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WELDING POSITIONS																							
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> <th>S</th> <th>FN</th> <th>FS</th> <th>FNW</th> </tr> </thead> <tbody> <tr> <td>0.02</td> <td>0.7</td> <td>1.4</td> <td>0.018</td> <td>23.5</td> <td>13</td> <td>2.5</td> <td>0.007</td> <td>18</td> <td>17</td> <td>27</td> </tr> </tbody> </table>	C	Si	Mn	P	Cr	Ni	Mo	S	FN	FS	FNW	0.02	0.7	1.4	0.018	23.5	13	2.5	0.007	18	17	27
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REDRYING	140°C / 24 hr																						
GAS ACC. EN ISO 14175	M21, C1																						