

CEWELD AA 309 LMoP

TYPE Stainless steel Rutile flux cored weldig wire. (Typ 309LMo, 23 12 2 L, 1.4459)

APPLICATIONS CEWELD® AA 309 LMoP you can use for 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 LMoP is a flux cored wire with rapidly solidifying slag (P in Standard) support for high productivity welding in all positions. Excellent for use on ceramic backing strips. The slag is self detaching and offers extra protection to obtain X-ray proof weld seams with practically no spatters. Better wetting and welding properties with more productivity compared to solid wires.

CLASSIFICATION

| | |
|--------|------------------------------|
| AWS | A 5.22: E309LMoT1-4 |
| EN ISO | 17633-A: T 23 12 2 L P M21 1 |
| 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 WELD METAL (%)

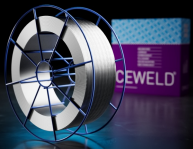
| C | Si | Mn | P | Cr | Ni | Mo | S | FN | FS | FNW |
|-------|------|-----|-------|----|------|-----|-------|----|----|-----|
| 0.025 | 0.55 | 0.9 | 0.015 | 23 | 12.5 | 2.5 | 0.015 | 18 | 17 | 25 |

MECHANICAL PROPERTIES

| Heat Treatment | R _{P0.2} (MPa) | R _m (MPa) | A ₅ (%) | Impact Energy (J) ISO-V | | Hardness |
|----------------|-------------------------|----------------------|--------------------|-------------------------|-------|----------|
| | | | | RT | -40°C | |
| As Welded | 400 | 600 | 32 | 110 | 27 | HRC |

REDRYING 140°C / 24 hr

GAS ACC. EN ISO 14175 M21, C1



CEWELD AA 309 LMoP

AA 309 LMOP 1,2MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| BS-300 | 15 | 8720663413796 |
| D-200 | 5 | 8720663413802 |