



# CEWELD SA 309LMo

**TYPE** Stainless steel solid wire

**TOEPASSINGEN** Cladding tanks, vessels, tubes etc. Welding dissimilar materials like carbon steel to stainless steels

**EIGENSCHAPPEN** SA 309LMo is a solid wire for SAW which operates with very stable, spatter free arcs. This wire deposits low carbon weld metal of about 23%Cr-13%Ni-2.3%Mo. Cladding on low alloyed steels in case a 18/8/2 CrNiMo layer is required in the first layer.

**CLASSIFICATIE**

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

**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 (%)**

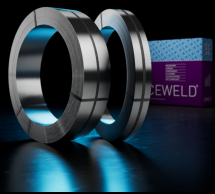
C	Si	Mn	P	S	Cr	Ni	Mo	Cu
0.015	0.4	1.8	0.015	0.01	24	13.5	2.6	0.12

**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	540	32	60		HRc

**HERDROGEN** Not required

**GAS ACC. EN ISO 14175**



# CEWELD SA 309LMo

SA 309LMO 2,0MM

Packaging	KG/unit	EanCode
K-415	25	8720663414267

SA 309LMO 2,4MM

Packaging	KG/unit	EanCode
K-415	25	8720663414274