



CEWELD SA 309LNb strip

TYPE Solid stainless steel welding strip. (Type 23 12 Nb, 1.4556)

APPLICATIONS Boilers, vessels, tube cladding, valves etc.

PROPERTIES Latest generation clean melting quality guarantees optimum metallurgical quality and attractive welder appeal. Combined with our high basic electro slag flux FL 830 ESH excellent results are obtained in both deposition rate as minimum delution rate due to the higher slag temperature compare to other electro slag fluxes.

CLASSIFICATION

AWS	A 5.9: EQ309LNb~
EN ISO	14343-A: B 22 12 L Nb
W.Nr.	1.4556

SUITABLE FOR SA 309LNb is developed for cladding applications in case AISI 347 is required in the first layer on mild steel.

APPROVALS CE

WELDING POSITIONS



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

C	Si	Mn	P	S	Cr	Ni	Nb
0.05	0.5	2	0.02	0.02	24	12.5	0.6

MECHANICAL PROPERTIES

Heat Treatment	R _{p0.2} (MPa)	R _m (MPa)	A5 (%)	Hardness
As Welded	450	600	>30	HRc

REDRYING Not required

GAS ACC. EN ISO 14175