

CEWELD SA 309LMo

TYPE Stainless steel solid wire for SAW Welding. (Type 309LMo, 23 12 2L, 1.4459)

APPLICATIONS CEWELD SA 309LMo is used for submerged arc cladding of unalloyed and low-alloy steels and for joint welding of dissimilar steels (black and white), such as unalloyed and low-alloy steels to high-alloy steels, where Mo plays a significant role. Cladding of tanks, containers, pipes etc.

PROPERTIES CEWELD 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, the weld metal already achieves approximately the composition of ASTM 316 in the 1st layer. For welding in combination with CEWELD FL 838 and CEWELD FL 880 welding fluxes.

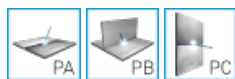
CLASSIFICATION

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

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 (%)

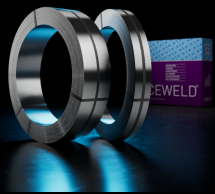
| C | Si | Mn | P | S | Cr | Ni | Mo | Cu |
|-------|-----|-----|-------|------|----|------|-----|------|
| 0.015 | 0.4 | 1.8 | 0.015 | 0.01 | 24 | 13.5 | 2.6 | 0.12 |

MECHANICAL PROPERTIES

| Heat Treatment | R _{P0.2} (MPa) | R _m (MPa) | A ₅ (%) | Impact Energy (J) ISO-V | | Hardness |
|----------------|-------------------------|----------------------|--------------------|-------------------------|--|----------|
| | | | | RT | | |
| As Welded | 370 | 540 | 32 | 60 | | HRC |

REDRYING 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 |