# CEWELD SA 309LMo strip

certilas® THE FILLER METAL SPECIALIST

| | |
|---|---|
| TYPE | Solid stainless steel welding strip |
| TOEPASSINGEN | Boilers, chemical industry components, offshore industry |
| EIGENSCHAPPEN | SA 309LMo strip is stainless steel strip for cladding overlay applications. Latest generation clean melting quality guarantees optimum metallurgical quality and attractive weld appeal. Combined with our high basic electro slag flux FL 830 ESHC excellent results are obtained in both deposition rate as minimum dilution rate due to the higher slag temperature compare to other electro slag fluxes. Cladding on low alloyed steels in case a 18/8/2 (AISI 316) CrNiMo layer is required in the first layer. |

CLASSIFICATIE

| | |
|---|---|
| AWS | A 5.9: EQ309LMo |
| EN ISO | 14343-A: B 23 12 2 L |
| W.Nr. | 1.4459 |

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 |
|---|---|---|---|---|---|---|---|
| 0.015 | 0.3 | 1.8 | 0.02 | 0.02 | 24 | 13 | 2.5 |

MECHANISCHE WAARDEN

| Heat Treatment | $R_{P0,2}$ (MPa) | Rm (MPa) | A5 (%) | Hardness |
|---|---|---|---|---|
| As Welded | 450 | 600 | >30 | HRc |

HERDROGEN: Not required

GAS ACC. EN ISO 14175