



CEWELD SA 309LMo strip

TYPE Solid stainless steel welding strip. (Type 1.4459, 23 12 2)

APPLICATIONS Boilers, chemical industry components, offshore industry

PROPERTIES CEWELD 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 ESH 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.

CLASSIFICATION

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

SUITABLE FOR **ISO 15608: 8.1 Austenitic $\leq 19\%$ 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
0.015	0.3	1.8	0.02	0.02	24	13	2.5

MECHANICAL PROPERTIES

Heat Treatment	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
As Welded	450	600	>30	HRc

REDRYING Not required

GAS ACC. EN ISO 14175