CEWELD 309H Tig

certilas® THE FILLER METAL SPECIALIST

TYPE

Solid stainless steel rod with high carbon content for high temperature applications. (Type 309H, 22 12, 1.4829

APPLICATIONS

CEWELD 309H Tig is scale resistant up to 1050° C. Buffer layers before hard facing, cladding and joining of similar austenitic steels, specially recommended for use in oxidizing gasses with nitrogen and gasses containing small amounts of oxygen.

PROPERTIES

CEWELD 309H Tig have high mechanical properties and very good weldability, suitable for high operating temperatures up to 1100°C.

CLASSIFICATION

AWS	A 5.9: ER309
EN ISO	14343-A: W 22 12 H
W.Nr.	1.4829
F-nr	6
FM	5

SUITABLE FOR

ISO 15608: 8.1 Austenitic ≤ 19 % Cr , TÜV 1000: Gr. 21, 23% Cr, 12%Ni Type
1.2780, 1.4541, 1.4550, 1.4710, 1.4712, 1.4713, 1.4724, 1.4729, 1. 4740, 1.4741, 1.4742, 1.4746, 1.4762, 1.4745, 1.4825, 1.4826, 1.4828, 1.4832, 1.4878,
X15CrNiSi20 12, G-X 40 CrNiSi20 9, G-X 30 CrSi 6, G-X 40 CrSi 13, G-X 40 CrSi 17, G-X 25 CrNiSi 18 9, X 15 CrNiSi 20 12, X 12 CrNiTi 18 9
AISI 446, 442, 309,
UNS S30900, S44200, S4460

APPROVALS

CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr	Ni
0.09	0.6	1.3	23	13

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V	Hardness
				RT	
As Welded	380	630	30	70	HRc

REDRYING

Not required

GAS ACC. EN ISO 14175

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