


# CEWELD 309H

TYPE	Solid stainless steel filler metal with high carbon content for high temperature applications. (Type 309H, 22 12, 1.4829)					
APPLICATIONS	Cladding on low alloyed steels in case a 18/8 CrNi layer is required in the first layer. 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	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: G 22 12 H				
	W.Nr.	1.4829				
	F-nr	6				
	FM	5				
SUITABLE FOR	<b>ISO 15608: 8.1 Austenitic ≤ 19 % Cr , TÜV 1000: Gr. 21, 23% Cr, 12%Ni Type</b> 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 THE FILLER METAL (%)	C	Si	Mn	Cr	Ni	
	0.1	0.7	1.3	23.5	13	
MECHANICAL PROPERTIES	Heat Treatment	R <sub>P0.2</sub> (MPa)	R <sub>m</sub> (MPa)	A5 (%)	Impact Energy (J) ISO-V	Hardness
	As Welded	400	600	25	RT	HRC
					70	
REDRYING	Not required					
GAS ACC. EN ISO 14175	M12					



# CEWELD 309H

309H 1,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720663413970

309H 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663413949

309H 1,6MM

Packaging	KG/unit	EanCode
BS-300	15	8720663413963