



# CEWELD 309LSi

**TYPE** Solid stainless steel welding wire for dissimilar welding. ( Type 1.4432, 23 12 LSi )

**APPLICATIONS** CEWELD 309LSi is for buffer layers before hard facing, dissimilar joints between ferritic and austenitic steels and or difficult to weld steels.

**PROPERTIES** High mechanical properties and very good weldability due to a ingreased silicon content, suitable for operating temperatures from -120°C up to 300°C.

**CLASSIFICATION**

AWS	A 5.9: ER309LSi
EN ISO	14343-A: G 23 12 L Si
W.Nr.	1.4332
F-nr	6
FM	5

**SUITABLE FOR** ISO 15608: 8.1 Austenitic ≤ 19 % Cr , TÜV 1000: Gr. 21-30, 23% Cr, 12%Ni Type  
 ISO 15608: Gr. 8.1 mix 1.1  
 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,  
 AISI 446, AISI442, AISI309,  
 UNS S30900, S44200, S44600

**APPROVALS** TÜV: 12395.00, CE

**WELDING POSITIONS**



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	Cr	Ni
	0.02	0.8	1.8	24	13

MECHANICAL PROPERTIES	Heat Treatment	R <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness
					RT	-196°C	
	As Welded	515	610	37	130	45	HRC

**REDRYING** Not required

**GAS ACC. EN ISO 14175** M11, M13, M12



# CEWELD 309LSi

## 309LSi 0,8MM

Packaging	KG/unit	EanCode
BS-300	15	8720663413857
D-100	1	8720663413864
D-200	5	8720663413871

## 309LSi 1,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720663413888
D-200	5	8720663413932
Drum	250	8720663413895

## 309LSi 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663413901
D-200	5	8720663413918
Drum	250	8720663413925

## 309LSi 1,6MM

Packaging	KG/unit	EanCode
BS-300	15	8720663413956