



CEWELD AA 309 LMo

TYPE	Rutile flux cored weldig wire for M21 and CO2. (Type 1.4459, 23 12 2)										
APPLICATIONS	Cladding applications in case a AISI 316 is required in the first layer, suitable for dissimilar welding of steel to stainless steel, heat resistant up to 1050 degrees Celsius.										
PROPERTIES	CEWELD AA 309 LMo is a rutile flux cored wire which operates with very stable, spatter free arc producing bright, smooth weld bead surfaces and self releasing slag. This wire deposits low carbon weld metal of about 23%Cr-13%Ni-2.3%Mo										
CLASSIFICATION	AWS	A 5.22: E309LMoT0-1, A 5.22: E309LMoT0-4									
	EN ISO	17633-A: T 23 12 2 L R M21 3, 17633-A: T 23 12 2 L R C1 3									
	W.Nr.	1.4459									
	F-nr	6									
	FM	5									
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	PAPBPCPF										
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	P	Cr	Ni	Mo	S	FN	FS	FNW
	0.02	0.7	1.4	0.018	23.5	13	2.5	0.007	18	17	27
MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V					Hardness	
	As Welded	540	700	30	-20°C					45	
										HRc	
REDRYING	140°C / 24 hr										
GAS ACC. EN ISO 14175	M21, C1										