CEWELD AA 309 L

certilas® THE FILLER METAL SPECIALIST

TYPE	Rutile fluxcored stainless steel welding wire for dissimilar welding. (Typ 309L, 23 12 L, 1.4332)
APPLICATIONS	Ceweld AA 309L is used for welding dissimilar steels and 13%Ni/18%Cr stainless steels, and is suitable for welding the first layer on low carbon steel to obtain a AISI 304 clad layer.
PROPERTIES	Smooth drop transfer and stable arc with no spatter losses.Excellent productivity and weldability, better wetting compared to solid wires.Excellent weld metal quality and X-ray soundness and excellent slag removal.Excellent for use in position and down hand as well. High resistance against moisture pick up.

CLASSIFICATION

AWS	A 5.22: E309LT0-1, A 5.22: E309LT0-4
EN ISO	17633-A: T 23 12 L R M21 3
W.Nr.	1.4332
F-nr	6
FM	5

SUITABLE FOR

ISO 15608: 8.1 Austenitic ≤ 19 % Cr , TÜV 1000: Gr. 21-30, Type 23% Cr, 12%Ni
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: CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	Cr	Ni	Mo	S	FN	FS	FNW
0.025	0.85	1.4	0.02	23	13	0.1	0.006	18	13	20

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
				RT	-20°C	
As Welded	420	560	38	60	43	HRc

REDRYING: 140°C / 24 hr

GAS ACC. EN ISO 14175: M21

CEWELD AA 309 L

AA 309 L 0,9MM

Packaging	KG/unit	EanCode
BS-300	12,5	8720663413741

AA 309 L 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663413765

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