




CEWELD SA 309LMo strip

TYPE	Solid stainless steel welding strip																	
APPLICATIONS	Boilers, chemical industry components, offshore industry																	
PROPRIÉTÉS	SA 309LMo strip is stainless steel strip for cladding overlay applications. Latest generation clean melting quality guarantees optimum metallurgical quality and attractive weld appeal. Combined with our high basic electro slag flux FL 830 ESHC excellent results are obtained in both deposition rate as minimum dilution rate due to the higher slag temperature compare to other electro slag fluxes. Cladding on low alloyed steels in case a 18/8/2 (AISI 316) CrNiMo layer is required in the first layer.																	
CLASSIFICATION	AWS EN ISO W.Nr.	A 5.9: EQ309LMo 14343-A: B 23 12 2 L 1.4459																
CONVIENT POUR	ISO 15608: 8.1 Austenitic ≤ 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																	
AGRÉMENTS	CE																	
POSITIONS DE SOUDAGE																		
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> </tr> </thead> <tbody> <tr> <td>0.015</td> <td>0.3</td> <td>1.8</td> <td>0.02</td> <td>0.02</td> <td>24</td> <td>13</td> <td>2.5</td> </tr> </tbody> </table>		C	Si	Mn	P	S	Cr	Ni	Mo	0.015	0.3	1.8	0.02	0.02	24	13	2.5
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As Welded	450	600	>30	HRc														
ETUVAGE	Not required																	
GAS ACC. EN ISO 14175																		