



CEWELD AA 309 LNb

TYPE Rutile flux cored stainless steel welding wire with exceptional Weldability for use with M21 and Co2. (Type 23 12 Nb, 1.4556)

APPLICATIONS Cladding mild and low alloyed steels in offshore and or chemical plants in case AISI 347 or AISI 321 are required as clad layer

PROPERTIES Smooth drop transfer and stable arc with no spatter losses. Excellent productivity and weldability, better wetting properties 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: E309LNbT0-1 |
| EN ISO | 17633-A: TZ 23 12 L Nb R M21 1 |
| W.Nr. | 1.4556 |
| F-nr | 6 |
| FM | 5 |

SUITABLE FOR **Type 23 12 Nb, E309LNb TÜV Groupe 29 (+22+21)**
 1.4878, 1.4825, 1.4541, 1.4550, 1.4552 1.4319, 1.4306, 1.4306, 1.4301, 1.4303, 1.4308, 1.4310, 1.4312
 X 12 CrNiTi 18 9, G-X 25 CrNiSi 27 4, X 6 NiTi 18 10, X 6CrNiNb 18 10, G-X 5CrNiNb 18 9, X 5CrNi 18 7, X 2CrNi 19 11, G-X 2CrNi 18 9, X 5CrNi 18 10, X 5CrNi 18 12 G-X, 6CrNi 18 9, X 12CrNi 17 7, G-X 10CrNi 18 8
 Cr - CrNi(Mo)- S355

APPROVALS CE

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

| C | Si | Mn | P | Cr | Ni | Nb+Ta | S | FN | FS | FNW |
|------|-----|-----|------|----|------|-------|------|----|----|-----|
| 0.03 | 0.7 | 1.4 | 0.02 | 23 | 12.5 | 0.8 | 0.08 | 18 | 16 | 25 |

MECHANICAL PROPERTIES

| Heat Treatment | R _{P0.2} (MPa) | R _m (MPa) | A ₅ (%) | Impact Energy (J) ISO-V | | Hardness |
|----------------|-------------------------|----------------------|--------------------|-------------------------|-----|----------|
| | | | | RT | 0°C | |
| As Welded | 480 | 650 | 35 | 80 | 70 | HRc |

REDRYING 140°C / 24 hr

GAS ACC. EN ISO 14175 M21, C1