



CEWELD AA 309 L

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%Cr/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
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 TÜV: 12423.00, CE

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

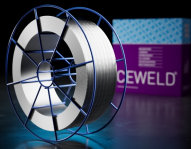
C	Si	Mn	P	Cr	Ni	Mo	S	FN	FS	FNW
0.025	0.85	1.4	0.02	23	13	0.1	0.006	18	13	20

MECHANICAL PROPERTIES

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	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