



# CEWELD SA 309LMo strip

TYPE Solid stainless steel welding strip

TOEPASSINGEN Boilers, chemical industry components, offshore industry

EIGENSCHAPPEN 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.

CLASSIFICATIE  
AWS A 5.9: EQ309LMo  
EN ISO 14343-A: B 23 12 2 L  
W.Nr. 1.4459

GESCHIKT VOOR  
**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

GOEDKEURINGEN CE

LASPOSITIES



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

| C     | Si  | Mn  | P    | S    | Cr | Ni | Mo  |
|-------|-----|-----|------|------|----|----|-----|
| 0.015 | 0.3 | 1.8 | 0.02 | 0.02 | 24 | 13 | 2.5 |

MECHANISCHE WAARDEN

| Heat Treatment | R <sub>p0.2</sub> (MPa) | R <sub>m</sub> (MPa) | A5 (%) | Hardness |
|----------------|-------------------------|----------------------|--------|----------|
| As Welded      | 450                     | 600                  | >30    | HRc      |

HERDROGEN Not required

GAS ACC. EN ISO 14175