CEWELD AA 309 LP

certilas® THE FILLER METAL SPECIALIST

TYPE

Rutile fluxcored stainless steel welding wire for dissimilar welding with fast freezing slag for position welding.(Type 309L, 23 12 L, 1.4332)

APPLICATIONS

CEWELD® AA 309 LP is a Rutile austenitic flux-cored wire of type T 23 12 L P / E309LT1 and used for welding dissimilar steels and 13%Cr/18%Cr stainless steels. He is suitable for welding the first layer on low carbon steel to obtain a AISI 304 clad layer. The rapidly solidifying slag offers excellent weldability and slag control in all positions. The easy handling and high deposition rate

PROPERTIES

CEWELD® AA 309 LP have a 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.Developped for use in position with maximum slag support. High resistance against moisture pick up.

CLASSIFICATION

AWS	A 5.22: E309LT1-1, A 5.22: E309LT1-4
EN ISO	17633-A: T 23 12 L P M21 2
W.Nr.	1.4332
F-nr	6
FM	5

SUITABLE FOR

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

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	Cr	Ni	Mo	S	FN	FS	FNW
0.026	0.86	1.4	0.021	23.5	13	0.15	0.006	17	12	14.7

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
				-20°C	-60°C	
As Welded	460	580	38	75	45	HRc

REDRYING

140°C / 24 hr

GAS ACC. EN ISO 14175

M21

CEWELD AA 309 LP

AA 309 LP 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663413772
D-200	5	8720663413758
D-270	15	8720663424631