



# CEWELD AA 309 LMoP

|                                             |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                           |                      |        |                         |      |       |       |          |    |     |
|---------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------|----------------------|--------|-------------------------|------|-------|-------|----------|----|-----|
| TYPE                                        | Stainless steel Rutile flux cored weldig wire. ( Typ 309LMo, 23 12 2 L, 1.4459)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                           |                      |        |                         |      |       |       |          |    |     |
| APPLICATIONS                                | CEWELD® AA 309 LMoP you can use for cladding applications in case a AISI 316 is required in the first layer, suitable for dissimilar welding of steel to stainless steel, heat resistant up to 1050 degrees Celsius                                                                                                                                                                                                                                                                                                                                                                                                    |                                                           |                      |        |                         |      |       |       |          |    |     |
| PROPERTIES                                  | CEWELD® AA 309 LMoP is a flux cored wire with rapidly solidifying slag (P in Standard) support for high productivity welding in all positions. Excellent for use on ceramic backing strips. The slag is self detaching and offers extra protection to obtain X-ray proof weld seams with practically no spatters. Better wetting and welding properties with more productivity compared to solid wires.                                                                                                                                                                                                                |                                                           |                      |        |                         |      |       |       |          |    |     |
| CLASSIFICATION                              | AWS                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | A 5.22: E309LMoT1-4, A 5.22: E309LMoT1-1                  |                      |        |                         |      |       |       |          |    |     |
|                                             | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | 17633-A: T 23 12 2 L P M21 1, 17633-A: T 23 12 2 L P C1 1 |                      |        |                         |      |       |       |          |    |     |
|                                             | W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | 1.4459                                                    |                      |        |                         |      |       |       |          |    |     |
|                                             | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | 6                                                         |                      |        |                         |      |       |       |          |    |     |
|                                             | FM                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | 5                                                         |                      |        |                         |      |       |       |          |    |     |
| SUITABLE FOR                                | ISO 15608: 8.1 Austenitic ≤ 19 % Cr , TÜV 1000: Gr. 21-30,<br>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,<br>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<br>316Cb, 316L, 316L, 316LN, 316H, 316, 316Ti, 316Cb, 316LN, 444<br>S31640, S31603, S31653, S31600, S31630, S44400                                                                                                                   |                                                           |                      |        |                         |      |       |       |          |    |     |
| APPROVALS                                   | CE                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                                           |                      |        |                         |      |       |       |          |    |     |
| WELDING POSITIONS                           | <div>      </div> |                                                           |                      |        |                         |      |       |       |          |    |     |
| TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | Si                                                        | Mn                   | P      | Cr                      | Ni   | Mo    | S     | FN       | FS | FNW |
|                                             | 0.025                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | 0.55                                                      | 0.9                  | 0.015  | 23                      | 12.5 | 2.5   | 0.015 | 18       | 17 | 25  |
| MECHANICAL PROPERTIES                       | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | R <sub>P0,2</sub> (MPa)                                   | R <sub>m</sub> (MPa) | A5 (%) | Impact Energy (J) ISO-V |      |       |       | Hardness |    |     |
|                                             |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                           |                      |        | RT                      |      | -40°C |       |          |    |     |
|                                             | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | 400                                                       | 600                  | 32     | 110                     |      | 27    |       | HRc      |    |     |
| REDRYING                                    | 140°C / 24 hr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                                           |                      |        |                         |      |       |       |          |    |     |
| GAS ACC. EN ISO 14175                       | M21, C1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                                           |                      |        |                         |      |       |       |          |    |     |



# CEWELD AA 309 LMoP

AA 309 LMOP 1,2MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663413796 |
| D-200     | 5       | 8720663413802 |