

CEWELD SA 309L

TYPE	Solid drawn stainless steel welding wire for SAW welding
APPLICATIONS	Buffer layers before hard facing, dissimilar joints between ferritic and austenitic steels and or difficult to weld steels.
PROPRIÉTÉS	High mechanical properties and very good weldability due to a increased silicon content, suitable for operating temperatures up to 300°C. Flux FL 838 of fused flux FL 880

CLASSIFICATION	AWS	A 5.9: ER309L
	EN ISO	14343-A: S 23 12 L
	W.Nr.	1.4332
	F-nr	6
	FM	5

CONVIENT POUR	ISO 15608: 8.1 Austenitic $\leq$ 19 % Cr (no Mo) ISO 15608: Gr. 8.1 mix 1.1 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
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AGRÉMENTS	CE
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POSITIONS DE SOUDAGE



ANALYSE CHIMIQUE TYPIQUE DU MÉTAL D'APPORT (%)

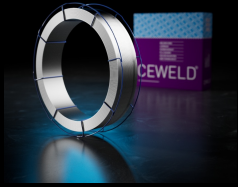
C	Si	Mn	P	S	Cr	Ni	Mo
0.02	0.55	2	0.02	0.02	24	13	0.2

PROPRIÉTÉS MÉCANIQUES

Heat Treatment	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V	Hardness
				RT	
As Welded	370	570	33	100	HRc

ETUVAGE	Not required
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GAS ACC. EN ISO 14175



CEWELD SA 309L

SA 309L 2,0MM

Packaging	KG/unit	EanCode
K-415	25	8720663414151

SA 309L 2,4MM

Packaging	KG/unit	EanCode
K-415	25	8720663414144

SA 309L 3,2MM

Packaging	KG/unit	EanCode
K-415	25	8720663414120

SA 309L 4,0MM

Packaging	KG/unit	EanCode
K-415	25	8720663414137