



# CEWELD SA 309LNb strip

**TYPE** Solid stainless steel welding strip. (Type 23 12 Nb, 1.4556)

**APPLICATIONS** Boilers, vessels, tube cladding, valves etc.

**PROPERTIES** Latest generation clean melting quality guarantees optimum metallurgical quality and attractive welder appeal. Combined with our high basic electro slag flux FL 830 ESH excellent results are obtained in both deposition rate as minimum delution rate due to the higher slag temperature compare to other electro slag fluxes.

**CLASSIFICATION**

AWS	A 5.9: EQ309LNb~
EN ISO	14343-A: B 22 12 L Nb
W.Nr.	1.4556

**SUITABLE FOR** SA 309LNb is developed for cladding applications in case AISI 347 is required in the first layer on mild steel.

**APPROVALS** CE

**WELDING POSITIONS**



**TYPICAL CHEMICAL  
ANALYSIS OF THE FILLER  
METAL (%)**

C	Si	Mn	P	S	Cr	Ni	Nb
0.05	0.5	2	0.02	0.02	24	12.5	0.6

**MECHANICAL PROPERTIES**

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

**REDRYING** Not required

**GAS ACC. EN ISO 14175**