



# CEWELD 309LMo Tig

**TYPE** Stainless steel Tig welding wire for dissimilar welding and cladding.(Typ 309LMo, 23 12 2 L, 1.4459)

**APPLICATIONS** CEWELD® 309LMo Tig is a solid, corrosion-resistant '309LMo' type wire used for overlay welding unalloyed and low-alloy steels, as well as dissimilar steels such as 316L to unalloyed and low-alloy steels, where molybdenum (Mo) is essential. It is also used for buffer layers before hard facing and for dissimilar joints between ferritic and austenitic steels, as well as for joining other stainless steel types to standard carbon steel. It is recommended for cladding on low-alloyed steel when AISI 316 is required as the initial layer.

**PROPERTIES** CEWELD® 309LMo Tig has excellent corrosion resistance in oxidising air up to 950°C. It has good resistance to hot cracking due to its high molybdenum content. During build-up welding, the weld metal achieves the composition of ASTM 316 in the first layer.

**CLASSIFICATION**

AWS	A 5.9: ER309LMo
EN ISO	14343-A: W 23 12 2 L
W.Nr.	1.4459
F-nr	6
FM	5

**SUITABLE FOR** **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, 316LN, 316H, 316, 316Ti, 316Cb, 316LN, 321, 410, 444  
S31640, S31603, S31653, S31600, S31630, S44400

**APPROVALS** CE

**WELDING POSITIONS**



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	P	S	Cr	Ni	Mo
	0.02	0.5	1.5	0.012	0.01	24	13	2.5

MECHANICAL PROPERTIES	Heat Treatment	R <sub>p0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness
					RT	-40°C	
	As Welded	400	600	31	110	60	HRc

**REDRYING** Not required

**GAS ACC. EN ISO 14175** I1



# CEWELD 309LMO Tig

309LMO TIG 1,6 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663414199
309LMO TIG 2,0 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663414205
309LMO TIG 2,4 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663414212
309LMO TIG 3,2 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663414830
309LMO TIG 4,0 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663414847