



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, 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	$R_{P0.2}$ (MPa)	R_m (MPa)	A5 (%)	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