



# CEWELD AA 309 L

|                                             |                                                                                                                                                                                                                                                                                                                                                                                                         |                                      |                      |                    |                         |    |       |       |          |    |     |
|---------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------|----------------------|--------------------|-------------------------|----|-------|-------|----------|----|-----|
| TYPE                                        | Rutile fluxcored stainless steel welding wire for dissimilar welding. (Typ 309L, 23 12 L, 1.4332)                                                                                                                                                                                                                                                                                                       |                                      |                      |                    |                         |    |       |       |          |    |     |
| APPLICATIONS                                | Ceweld AA 309L is used for welding dissimilar steels and 13%Cr/18%Cr stainless steels, and is suitable for welding the first layer on low carbon steel to obtain a AISI 304 clad layer.                                                                                                                                                                                                                 |                                      |                      |                    |                         |    |       |       |          |    |     |
| PROPERTIES                                  | Smooth drop transfer and stable arc with no spatter losses.Excellent productivity and weldability, better wetting compared to solid wires.Excellent weld metal quality and X-ray soundness and excellent slag removal.Excellent for use in position and down hand as well. High resistance against moisture pick up.                                                                                    |                                      |                      |                    |                         |    |       |       |          |    |     |
| CLASSIFICATION                              | AWS                                                                                                                                                                                                                                                                                                                                                                                                     | A 5.22: E309LT0-1, A 5.22: E309LT0-4 |                      |                    |                         |    |       |       |          |    |     |
|                                             | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                  | 17633-A: T 23 12 L R M21 3           |                      |                    |                         |    |       |       |          |    |     |
|                                             | W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                   | 1.4332                               |                      |                    |                         |    |       |       |          |    |     |
|                                             | F-nr                                                                                                                                                                                                                                                                                                                                                                                                    | 6                                    |                      |                    |                         |    |       |       |          |    |     |
|                                             | FM                                                                                                                                                                                                                                                                                                                                                                                                      | 5                                    |                      |                    |                         |    |       |       |          |    |     |
| SUITABLE FOR                                | ISO 15608: 8.1 Austenitic ≤ 19 % Cr , TÜV 1000: Gr. 21-30, Type 23% Cr, 12%Ni<br>1.2780, 1.4541, 1.4550, <b>1.4710, 1.4712</b> , 1.4713, 1.4724, 1.4729, 1.4740, 1.4741, 1.4742, 1.4746, 1.4762, 1.4745, <b>1.4825, 1.4826, 1.4828, 1.4832, 1.4878</b> ,<br>X15CrNiSi20 12, G-X 40 CrNiSi20 9,<br>AISI 446, AISI442, AISI309,<br>UNS S30900, S44200, S44600                                             |                                      |                      |                    |                         |    |       |       |          |    |     |
| APPROVALS                                   | CE                                                                                                                                                                                                                                                                                                                                                                                                      |                                      |                      |                    |                         |    |       |       |          |    |     |
| WELDING POSITIONS                           | <div> PA</div> <div> PB</div> <div> PC</div> <div> PF</div> |                                      |                      |                    |                         |    |       |       |          |    |     |
| TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%) | C                                                                                                                                                                                                                                                                                                                                                                                                       | Si                                   | Mn                   | P                  | Cr                      | Ni | Mo    | S     | FN       | FS | FNW |
|                                             | 0.025                                                                                                                                                                                                                                                                                                                                                                                                   | 0.85                                 | 1.4                  | 0.02               | 23                      | 13 | 0.1   | 0.006 | 18       | 13 | 20  |
| 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                      |    | -20°C |       |          |    |     |
|                                             | As Welded                                                                                                                                                                                                                                                                                                                                                                                               | 420                                  | 560                  | 38                 | 60                      |    | 43    |       | HRc      |    |     |
| REDRYING                                    | 140°C / 24 hr                                                                                                                                                                                                                                                                                                                                                                                           |                                      |                      |                    |                         |    |       |       |          |    |     |
| GAS ACC. EN ISO 14175                       | M21                                                                                                                                                                                                                                                                                                                                                                                                     |                                      |                      |                    |                         |    |       |       |          |    |     |



# CEWELD AA 309 L

AA 309 L 0,9MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 12,5    | 8720663413741 |

AA 309 L 1,2MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663413765 |