

CEWELD SA 309L

TYPE Solid drawn stainless steel welding wire for SAW welding. (Type 309L, 23 12 L, 1.4332)

APPLICATIONS CEWELD SA 309L is an austenitic SAW solid wire of type S 23 12 L / E309L and is used for SAW welding of dissimilar steels and 13%Cr/18%Cr stainless steels. It is suitable for welding the first layer on low carbon steel to obtain a clad layer AISI 304

PROPERTIES CEWELD SA 309L shows high mechanical properties and very good weldability, suitable for operating temperatures up to 300°C. For welding in combination with CEWELD FL 838 and CEWELD FL 880 welding fluxes.

CLASSIFICATION

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

SUITABLE FOR

ISO 15608: 8.1 Austenitic ≤ 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

APPROVALS CE

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

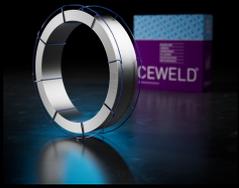
C	Si	Mn	P	S	Cr	Ni	Mo
0.02	0.55	2	0.02	0.02	24	13	0.2

MECHANICAL PROPERTIES

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

REDRYING Not required

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