



# CEWELD 309LSi

|                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                         |                      |                    |                         |         |
|---------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------|----------------------|--------------------|-------------------------|---------|
| TYPE                                              | Massieve lasdraad voor het lassen van roestvaststaal en ongelijksoortige verbindingen.                                                                                                                                                                                                                                                                                                                                                          |                         |                      |                    |                         |         |
| TOEPASSINGEN                                      | Bufferlagen voor hardoplassingen, ongelijksoortige verbindingen tussen ferritische en austenitische staalsoorten en/of moeilijk te lassen staalsoorten.                                                                                                                                                                                                                                                                                         |                         |                      |                    |                         |         |
| EIGENSCHAPPEN                                     | Hoge mechanische eigenschappen en zeer goede lasbaarheid dankzij een verhoogd siliciumgehalte, geschikt voor bedrijfstemperaturen tot 300 °C.                                                                                                                                                                                                                                                                                                   |                         |                      |                    |                         |         |
| CLASSIFICATIE                                     | AWS                                                                                                                                                                                                                                                                                                                                                                                                                                             | A 5.9: ER309LSi         |                      |                    |                         |         |
|                                                   | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                          | 14343-A: G 23 12 L Si   |                      |                    |                         |         |
|                                                   | W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                                                           | 1.4332                  |                      |                    |                         |         |
|                                                   | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                            | 6                       |                      |                    |                         |         |
|                                                   | FM                                                                                                                                                                                                                                                                                                                                                                                                                                              | 5                       |                      |                    |                         |         |
| GESCHIKT VOOR                                     | <b>ISO 15608: 8.1 Austenitic ≤ 19 % Cr ( no Mo)</b><br><b>ISO 15608: Gr. 8.1 mix 1.1</b><br>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,<br>X15CrNiSi20 12, G-X 40 CrNiSi20 9,<br>AISI 446, AISI442, AISI309,<br>UNS S30900, S44200, S44600                                                                                          |                         |                      |                    |                         |         |
| GOEDKEURINGEN                                     | TÜV: (12395), CE                                                                                                                                                                                                                                                                                                                                                                                                                                |                         |                      |                    |                         |         |
| LASPOSITIES                                       | <div>PAPBPCPDPE</div> |                         |                      |                    |                         |         |
| TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                               | Si                      | Mn                   | Cr                 | Ni                      |         |
|                                                   | 0.02                                                                                                                                                                                                                                                                                                                                                                                                                                            | 0.8                     | 1.8                  | 24                 | 13                      |         |
| MECHANISCHE WAARDEN                               | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                  | R <sub>p0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V |         |
|                                                   | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                       | 515                     | 610                  | 37                 | RT                      | -196 °C |
|                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                         |                      |                    | 130                     | 45      |
|                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                         |                      |                    |                         | HRc     |
| HERDROGEN                                         | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                    |                         |                      |                    |                         |         |
| GAS ACC. EN ISO 14175                             | M11, M13, M12                                                                                                                                                                                                                                                                                                                                                                                                                                   |                         |                      |                    |                         |         |



# CEWELD 309LSi

## 309LSi 0,8MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663413857 |
| D-100     | 1       | 8720663413864 |
| D-200     | 5       | 8720663413871 |

## 309LSi 1,0MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663413888 |
| D-200     | 5       | 8720663413932 |
| Drum      | 250     | 8720663413895 |

## 309LSi 1,2MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663413901 |
| D-200     | 5       | 8720663413918 |
| Drum      | 250     | 8720663413925 |

## 309LSi 1,6MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663413956 |