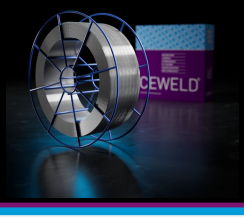


CEWELD 309LSi

certilas® THE FILLER METAL SPECIALIST

TYPE	Solid stainless steel welding wire for dissimilar welding. (Type 1.4432, 23 12 LSi)
APPLICATIONS	CEWELD 309LSi is for buffer layers before hard facing, dissimilar joints between ferritic and austenitic steels and or difficult to weld steels.
PROPERTIES	High mechanical properties and very good weldability due to a ingreased silicon content, suitable for operating temperatures from -120°C up to 300°C.

CLASSIFICATION

AWS	A 5.9: ER309LSi
EN ISO	14343-A: G 23 12 L Si
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: TÜV: (12395), CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

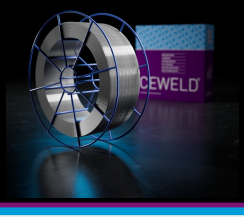
C	Si	Mn	Cr	Ni
0.02	0.8	1.8	24	13

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
				RT	-196°C	
As Welded	515	610	37	130	45	HRc

REDRYING: Not required

GAS ACC. EN ISO 14175: M11, M13, M12



CEWELD 309LSi

certilas® THE FILLER METAL SPECIALIST

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