



# CEWELD 309LSi Tig

|                                                      |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                         |                      |                    |                         |        |          |
|------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------|----------------------|--------------------|-------------------------|--------|----------|
| TYPE                                                 | Fil de soudage 309LSi, acier inoxydable pour le soudage de matériaux dissimilaires                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                         |                      |                    |                         |        |          |
| APPLICATIONS                                         | Sous-couches avant rechargement, soudure dissimilaires entre l'acier et l'acier inoxydable, acier difficile à souder, etc.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                         |                      |                    |                         |        |          |
| PROPRIÉTÉS                                           | Propriétés mécaniques élevées et très bonne soudabilité grâce à la teneur en silicium, adaptées à des températures de service jusqu'à 300°C.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                         |                      |                    |                         |        |          |
| CLASSIFICATION                                       | AWS                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | A 5.9: ER309LSi         |                      |                    |                         |        |          |
|                                                      | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               | 14343-A: W 23 12 L Si   |                      |                    |                         |        |          |
|                                                      | W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | 1.4432                  |                      |                    |                         |        |          |
|                                                      | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | 6                       |                      |                    |                         |        |          |
|                                                      | FM                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | 5                       |                      |                    |                         |        |          |
| CONVIENT POUR                                        | ISO 15608: 8.1 Austenitic ≤ 19 % Cr ( no Mo)<br>ISO 15608: Gr. 8.1 mix 1.1<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                                                                                                                                                                                                                                                                                             |                         |                      |                    |                         |        |          |
| AGRÉMENTS                                            | TÜV: (12394), CE                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                         |                      |                    |                         |        |          |
| POSITIONS DE SOUDAGE                                 | <div> PA  PB  PC  PD  PE  PF  PG</div> |                         |                      |                    |                         |        |          |
| ANALYSE CHIMIQUE<br>TYPIQUE DU MÉTAL<br>D'APPORT (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | Si                      | Mn                   | P                  | S                       | Cr     | Ni       |
|                                                      | 0.02                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | 0.7                     | 1.7                  | 0.01               | 0.01                    | 24     | 13       |
| PROPRIÉTÉS MÉCANIQUES                                | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | R <sub>p0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V |        | Hardness |
|                                                      |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                         |                      |                    | RT                      | -196°C |          |
|                                                      | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | 535                     | 640                  | 37                 | 140                     | 50     | HRc      |
| ETUVAGE                                              | Not requis                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                         |                      |                    |                         |        |          |
| GAS ACC. EN ISO 14175                                | I1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                         |                      |                    |                         |        |          |



# CEWELD 309LSi Tig

|                         |           |         |               |
|-------------------------|-----------|---------|---------------|
| 309LSI TIG 1,0 X 1000MM | Packaging | KG/unit | EanCode       |
|                         | Tube      | 5       | 8720663413987 |
| 309LSI TIG 1,2 X 1000MM | Packaging | KG/unit | EanCode       |
|                         | Tube      | 5       | 8720663414007 |
| 309LSI TIG 1,6 X 1000MM | Packaging | KG/unit | EanCode       |
|                         | Tube      | 5       | 8720663413994 |
| 309LSI TIG 1,6 X 500MM  | Packaging | KG/unit | EanCode       |
|                         | Tube      | 5       | 8720663414014 |
| 309LSI TIG 2,0 X 1000MM | Packaging | KG/unit | EanCode       |
|                         | Tube      | 5       | 8720663414021 |
| 309LSI TIG 2,0 X 500MM  | Packaging | KG/unit | EanCode       |
|                         | Tube      | 5       | 8720663414045 |
| 309LSI TIG 2,4 X 1000MM | Packaging | KG/unit | EanCode       |
|                         | Tube      | 5       | 8720663414069 |
| 309LSI TIG 2,4 X 500MM  | Packaging | KG/unit | EanCode       |
|                         | Tube      | 5       | 8720663414083 |
| 309LSI TIG 3,2 X 1000MM | Packaging | KG/unit | EanCode       |
|                         | Tube      | 5       | 8720663414090 |
| 309LSI TIG 4,0 X 1000MM | Packaging | KG/unit | EanCode       |
|                         | Tube      | 5       | 8720663414182 |