



CEWELD SA 308L strip

TYPE	Stainless steel strip for ESW	
APPLICATIONS	Cladding surfaces	
PROPRIÉTÉS	Strip with 19Cr/9Ni composition, ESW process has very low dilution so in the first layer you almost reach the chemical composition. Flux FL 860 ESH can be used.	
CLASSIFICATION	AWS EN ISO FM	A 5.9: EQ308L 14343-A: B 19 9 L 1.4316

CONVIENT POUR **ISO 15608: 8.1 Austenitic $\leq$ 19 % Cr 9% Ni, TÜV 1000: Gr. 21 - 22 (29 max.350°C), 1.4301, 1.4306, 1.4307, 1.4308, 1.4311, 1.4312, 1.6900, 1.6901, 1.6902, 1.6903, 1.9606, 1.4541, 1.4546, 1.4550 X 5 CrNi 18 10, X 2 CrNi 19 11, X 5 CrNi 18 9, G-X 6 CrNi 18 9, X 12 CrNi 18 9, G-X 8 CrNi 18 10, X 6 CrNi 18 10, X 10 CrNiTi 18 10, X 5 CrNi 18 10 AISI 304, 304H, 312, 321H, 347, 347H, UNS S30409, S32109, S34709, S30400, S32100, S34700**

AGRÉMENTS CE

POSITIONS DE SOUDAGE 

ANALYSE CHIMIQUE TYPIQUE DU MÉTAL D'APPORT (%)	C	Si	Mn	P	S	Cr	Ni	Mo
	0.02	0.55	2	0.02	0.01	21	10	0.5

PROPRIÉTÉS MÉCANIQUES	Heat Treatment	R _{p0.2} (MPa)	R _m (MPa)	A5 (%)	Hardness
	As Welded	450	600	>35	HRc

ETUVAGE Not required

GAS ACC. EN ISO 14175