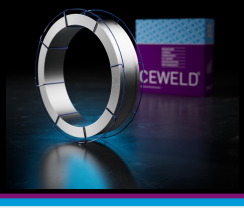


CEWELD SA 309L

certilas® THE FILLER METAL SPECIALIST

TYPE	Solid drawn stainless steel welding wire for SAW welding
TOEPASSINGEN	Buffer layers before hard facing, dissimilar joints between ferritic and austenitic steels and or difficult to weld steels.
EIGENSCHAPPEN	High mechanical properties and very good weldability due to a increased silicon content, suitable for operating temperatures up to 300°C. Flux FL 838 of fused flux FL 880

CLASSIFICATIE

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

GESCHIKT VOOR

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

GOEDKEURINGEN: CE

LASPOSITIES

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

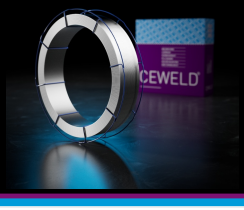
C	Si	Mn	P	S	Cr	Ni	Mo
0.02	0.55	2	0.02	0.02	24	13	0.2

MECHANISCHE WAARDEN

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V	Hardness
				RT	
As Welded	370	570	33	100	HRc

HERDROGEN: 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