



# CEWELD SA 309L

TYPE

APPLICATIONS

PROPRIÉTÉS

CLASSIFICATION

CONVIENT POUR

AGRÉMENTS

POSITIONS DE SOUDAGE

ANALYSE CHIMIQUE  
TYPIQUE DU MÉTAL  
D'APPORT (%)

PROPRIÉTÉS MÉCANIQUES

ETUVAGE

GAS ACC. EN ISO 14175

Solid drawn stainless steel welding wire for SAW welding

Buffer layers before hard facing, dissimilar joints between ferritic and austenitic steels and or difficult to weld steels.

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

AWS

EN ISO

W.Nr.

F-nr

FM

A 5.9: ER309L

14343-A: S 23 12 L

1.4332

6

5

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

CE

PA

PB

PC

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

| Heat Treatment | R <sub>P0,2</sub><br>(MPa) | R <sub>m</sub><br>(MPa) | A <sub>5</sub><br>(%) | Impact Energy (J) ISO-V | Hardness |
|----------------|----------------------------|-------------------------|-----------------------|-------------------------|----------|
|                |                            |                         |                       | RT                      |          |
| As Welded      | 370                        | 570                     | 33                    | 100                     | HRc      |

Not required



# 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 |