



CEWELD SA 309L

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	 PA  PB  PC							
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)	R _m (MPa)	A ₅ (%)	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