



CEWELD 309LSi

TYPE Solid stainless steel welding wire for dissimilar welding. (Type 1.4432, 23 12 LSi)

APPLICATIONS CEWELD 309LSi is for buffer layers before hard facing, dissimilar joints between ferritic and austenitic steels and or difficult to weld steels.

PROPERTIES High mechanical properties and very good weldability due to a ingreased silicon content, suitable for operating temperatures from -120°C up to 300°C.

CLASSIFICATION

AWS	A 5.9: ER309LSi
EN ISO	14343-A: G 23 12 L Si
F-nr	6
FM	5
W.Nr.	1.4332

SUITABLE FOR ISO 15608: 8.1 Austenitic ≤ 19 % Cr , TÜV 1000: Gr. 21-30, 23% Cr, 12%Ni Type
 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

APPROVALS TÜV (12395.00) CE

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	Cr	Ni
0.02	0.8	1.8	24	13

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V	
				RT	-196°C
As Welded /	515	610	37	130	45

REDRYING TEMPERATURE Not required

GAS ACCORDING EN 14175 M11, M13, M12



CEWELD 309LSi

309LSi 0,8MM

Type	KG/unit	EANCode
BS-300	15	8720663413857
D-100	1	8720663413864
D-200	5	8720663413871

309LSi 1,0MM

Type	KG/unit	EANCode
BS-300	15	8720663413888
D-200	5	8720663413932
Drum	250	8720663413895

309LSi 1,2MM

Type	KG/unit	EANCode
BS-300	15	8720663413901
D-200	5	8720663413918
Drum	250	8720663413925

309LSi 1,6MM

Type	KG/unit	EANCode
BS-300	15	8720663413956