

CEWELD 309LMo Tig

TYPE Stainless steel Tig welding wire for dissimilar welding and cladding.(Typ 309LMo, 23 12 2 L, 1.4459)

APPLICATIONS A continuous, solid, corrosion-resistant wire of the "309LMo" type. CEWELD 309LMo is used for the overlay welding of unalloyed and low-alloyed steels and for welding dissimilar steels, such as 316L, to unalloyed and low-alloyed steels when Mo is essential. Buffer layers before hard facing, dissimilar joints between ferritic and austenitic steels and or other stainless steel types to standard carbon steel. Recommended for cladding on low alloyed steel in case AISI 316 is required as first layer.

PROPERTIES Excelent corrosion resistance against oxidising air upto 950°C. Good resistance against hot cracking due to the high Mo content. During build-up welding, the weld metal already achieves approximately the composition of ASTM 316 in the 1st layer.

CLASSIFICATION

AWS	A 5.9: ER309LMo
EN ISO	14343-A: W 23 12 2 L
F-nr	6
FM	5
W.Nr.	1.4459

SUITABLE FOR **ISO 15608: 8.1 Austenitic ≤ 19 % Cr , TÜV 1000: Gr. 21-30,**
 1.4583, 1.4435, 1.4436, 1.4404, 1.4406, 1.4408, 1.4401, 1.4571, 1.4580, 1.4406, 1.4521, 1.4301, 1.4306,
 X102CrNiMoNb 18 12, X2CrNiMo 18 14 3 (TP), X4CrNiMo 17 13 3, X2CrNiMo 17 12 2 (TP), X 5CrNiMo 19 11 2, X4CrNiMo 17 12 2 (TP), X6CrNiMo 17 12 2, X6CrNiMoNb 17 12 3, X2CrNiMoN 17 12 3 (TP), X2CrMoTi18-2
 316Cb, 316L, 316LN, 316H, 316, 316Ti, 316Cb, 316LN, 444
 S31640, S31603, S31653, S31600, S31630, S44400

APPROVALS CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

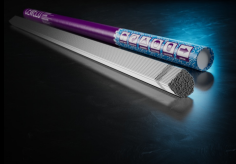
C	Si	Mn	P	S	Cr	Ni	Mo	FN
0.02	0.5	1.8	0.012	0.01	24	13	2.5	9

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V	
				RT	-40°C
As Welded /	400	600	31	110	60

REDRYING TEMPERATURE Not required

GAS ACCORDING EN 14175 I1



CEWELD 309LMo Tig

309LMO TIG 1,6 X 1000MM	Type	KG/unit	EANCode
	Tube	5	8720663414199
309LMO TIG 2,0 X 1000MM	Type	KG/unit	EANCode
	Tube	5	8720663414205
309LMO TIG 2,4 X 1000MM	Type	KG/unit	EANCode
	Tube	5	8720663414212
309LMO TIG 3,2 X 1000MM	Type	KG/unit	EANCode
	Tube	5	8720663414830
309LMO TIG 4,0 X 1000MM	Type	KG/unit	EANCode
	Tube	5	8720663414847