



CEWELD 309LSi Tig

TYPE	Stainless steel filler metal for dissimilar welding between steel and stainless steel and difficult to weld steels.(Type 1.4432, 23 12 LSi)															
APPLICATIONS	CEWELD 309LSi Tig 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: W 23 12 L Si														
	F-nr	6														
	FM	5														
	W.Nr.	1.4432														
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, 1.2, 1.3, 2.1, 2.2, 3.1 , 3.2 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 (TÜV (12394.00)) CE															
WELDING POSITIONS																
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Cr</th> <th>Ni</th> </tr> </thead> <tbody> <tr> <td>0.02</td> <td>0.7</td> <td>1.7</td> <td>0.01</td> <td>0.01</td> <td>24</td> <td>13</td> </tr> </tbody> </table>	C	Si	Mn	P	S	Cr	Ni	0.02	0.7	1.7	0.01	0.01	24	13	
C	Si	Mn	P	S	Cr	Ni										
0.02	0.7	1.7	0.01	0.01	24	13										
ALL WELD MECHANICAL PROPERTIES	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th>Heat Treatment</th> <th>R_{P0,2} MPa</th> <th>R_m MPa</th> <th>A₅ (%)</th> <th>Impact Energy (J) ISO-V RT</th> <th>-196°C</th> </tr> </thead> <tbody> <tr> <td>As Welded /</td> <td>535</td> <td>640</td> <td>37</td> <td>140</td> <td>50</td> </tr> </tbody> </table>	Heat Treatment	R _{P0,2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V RT	-196°C	As Welded /	535	640	37	140	50			
Heat Treatment	R _{P0,2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V RT	-196°C											
As Welded /	535	640	37	140	50											
REDRYING TEMPERATURE	Not required															
GAS ACCORDING EN 14175	I1															



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309LSI TIG 1,0 X 1000MM	Type	KG/unit	EANCode
	Tube	5	8720663413987
309LSI TIG 1,2 X 1000MM	Type	KG/unit	EANCode
	Tube	5	8720663414007
309LSI TIG 1,6 X 1000MM	Type	KG/unit	EANCode
	Tube	5	8720663413994
309LSI TIG 1,6 X 500MM	Type	KG/unit	EANCode
	Tube	5	8720663414014
309LSI TIG 2,0 X 1000MM	Type	KG/unit	EANCode
	Tube	5	8720663414021
309LSI TIG 2,0 X 500MM	Type	KG/unit	EANCode
	Tube	5	8720663414045
309LSI TIG 2,4 X 1000MM	Type	KG/unit	EANCode
	Tube	5	8720663414069
309LSI TIG 2,4 X 500MM	Type	KG/unit	EANCode
	Tube	5	8720663414083
309LSI TIG 3,2 X 1000MM	Type	KG/unit	EANCode
	Tube	5	8720663414090
309LSI TIG 4,0 X 1000MM	Type	KG/unit	EANCode
	Tube	5	8720663414182