CEWELD 309LSi Tig

certilas® THE FILLER METAL SPECIALIST

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 (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

APPROVALS

TÜV ((12394)) CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	P	S	Cr	Ni
0.02	0.7	1.7	0.01	0.01	24	13

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)	Impact Energy (J) ISO-V RT	Impact Energy (J) ISO-V -196°C
As Welded /	535	640	37	140	50

REDRYING TEMPERATURE

Not required

GAS ACCORDING EN 14175

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