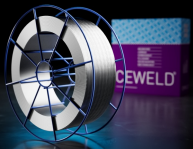


CEWELD AA 309 LP

TYPE	Rutile fluxcored stainless steel welding wire for dissimilar welding with fast freezing slag for position welding.(Type 309L, 23 12 L, 1.4332)																						
APPLICATIONS	CEWELD® AA 309 LP is a Rutile austenitic flux-cored wire of type T 23 12 L P / E309LT1 and used for welding dissimilar steels and 13%Cr/18%Cr stainless steels. He is suitable for welding the first layer on low carbon steel to obtain a AISI 304 clad layer. The rapidly solidifying slag offers excellent weldability and slag control in all positions. The easy handling and high deposition rate																						
PROPERTIES	CEWELD® AA 309 LP have a smooth drop transfer and stable arc with no spatter losses. Excellent productivity and weldability, better wetting compared to solid wires.Excellent weld metal quality and X-ray soundness and excellent slag removal.Developped for use in position with maximum slag support. High resistance against moisture pick up.																						
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.22: E309LT1-1</td> </tr> <tr> <td>AWS</td> <td>A 5.22: E309LT1-4</td> </tr> <tr> <td>EN ISO</td> <td>17633-A: T 23 12 L P M21 2</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>5</td> </tr> <tr> <td>W.Nr.</td> <td>1.4332</td> </tr> </table>	AWS	A 5.22: E309LT1-1	AWS	A 5.22: E309LT1-4	EN ISO	17633-A: T 23 12 L P M21 2	F-nr	6	FM	5	W.Nr.	1.4332										
AWS	A 5.22: E309LT1-1																						
AWS	A 5.22: E309LT1-4																						
EN ISO	17633-A: T 23 12 L P M21 2																						
F-nr	6																						
FM	5																						
W.Nr.	1.4332																						
SUITABLE FOR	<p>ISO 15608: 8.1 Austenitic ≤ 19 % Cr , TÜV 1000: Gr. 21-30, 23% Cr, 12%Ni Type 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</p>																						
APPROVALS	CE Lloyds DNV																						
WELDING POSITIONS																							
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> <th>S</th> <th>FN</th> <th>FS</th> <th>FNW</th> </tr> </thead> <tbody> <tr> <td>0.026</td> <td>0.86</td> <td>1.4</td> <td>0.021</td> <td>23.5</td> <td>13</td> <td>0.15</td> <td>0.006</td> <td>17</td> <td>12</td> <td>14.7</td> </tr> </tbody> </table>	C	Si	Mn	P	Cr	Ni	Mo	S	FN	FS	FNW	0.026	0.86	1.4	0.021	23.5	13	0.15	0.006	17	12	14.7
C	Si	Mn	P	Cr	Ni	Mo	S	FN	FS	FNW													
0.026	0.86	1.4	0.021	23.5	13	0.15	0.006	17	12	14.7													
ALL WELD MECHANICAL PROPERTIES	<table border="1"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R_{P0,2} MPa</th> <th rowspan="2">R_m MPa</th> <th rowspan="2">A₅ (%)</th> <th colspan="2">Impact Energy (J) ISO-V</th> </tr> <tr> <th>-20°C</th> <th>-60°C</th> </tr> </thead> <tbody> <tr> <td>As Welded /</td> <td>460</td> <td>580</td> <td>38</td> <td>75</td> <td>45</td> </tr> </tbody> </table>	Heat Treatment	R _{P0,2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V		-20°C	-60°C	As Welded /	460	580	38	75	45								
Heat Treatment	R _{P0,2} MPa					R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V															
		-20°C	-60°C																				
As Welded /	460	580	38	75	45																		
REDRYING TEMPERATURE	140°C / 24 hr																						
GAS ACCORDING EN 14175	M21																						



CEWELD AA 309 LP

AA 309 LP 1,2MM

Type	KG/unit	EANCode
BS-300	15	8720663413772
D-200	5	8720663413758
D-270	15	8720663424631