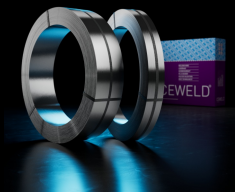


# CEWELD SA 309LMo

|                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                       |                       |                               |                       |                       |                               |             |     |     |    |       |     |     |       |      |    |      |     |      |
|---------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------|-----------------------|-------------------------------|-----------------------|-----------------------|-------------------------------|-------------|-----|-----|----|-------|-----|-----|-------|------|----|------|-----|------|
| TYPE                                              | Stainless steel solid wire for SAW Welding. ( Type 309LMo, 23 12 2L, 1.4459)                                                                                                                                                                                                                                                                                                                                                                                                                              |                       |                       |                               |                       |                       |                               |             |     |     |    |       |     |     |       |      |    |      |     |      |
| APPLICATIONS                                      | CEWELD SA 309LMo is used for submerged arc cladding of unalloyed and low-alloy steels and for joint welding of dissimilar steels (black and white), such as unalloyed and low-alloy steels to high-alloy steels, where Mo plays a significant role. Cladding of tanks, containers, pipes etc.                                                                                                                                                                                                             |                       |                       |                               |                       |                       |                               |             |     |     |    |       |     |     |       |      |    |      |     |      |
| PROPERTIES                                        | CEWELD SA 309LMo is a solid wire for SAW which operates with very stable, spatter free arcs. This wire deposits low carbon weld metal of about 23%Cr-13%Ni-2.3%Mo. Cladding on low alloyed steels,the weld metal already achieves approximately the composition of ASTM 316 in the 1st layer. For welding in combination with CEWELD FL 838 and CEWELD FL 880 welding fluxes.                                                                                                                             |                       |                       |                               |                       |                       |                               |             |     |     |    |       |     |     |       |      |    |      |     |      |
| CLASSIFICATION                                    | AWS                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | A 5.9: ER309LMo       |                       |                               |                       |                       |                               |             |     |     |    |       |     |     |       |      |    |      |     |      |
|                                                   | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | 14343-A: S 23 12 2 L  |                       |                               |                       |                       |                               |             |     |     |    |       |     |     |       |      |    |      |     |      |
|                                                   | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | 5                     |                       |                               |                       |                       |                               |             |     |     |    |       |     |     |       |      |    |      |     |      |
|                                                   | FM                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | 6                     |                       |                               |                       |                       |                               |             |     |     |    |       |     |     |       |      |    |      |     |      |
|                                                   | W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | 1.4459                |                       |                               |                       |                       |                               |             |     |     |    |       |     |     |       |      |    |      |     |      |
| SUITABLE FOR                                      | <b>ISO 15608: 8.1 Austenit ≤ 19 % Cr , TÜV 1000: Gr. 21-30,</b><br>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,<br>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<br>316Cb, 316L, 316L, 316LN, 316H, 316, 316Ti, 316Cb, 316LN, 444<br>S31640, S31603, S31653, S31600, S31630, S44400 |                       |                       |                               |                       |                       |                               |             |     |     |    |       |     |     |       |      |    |      |     |      |
| APPROVALS                                         | CE                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                       |                       |                               |                       |                       |                               |             |     |     |    |       |     |     |       |      |    |      |     |      |
| WELDING POSITIONS                                 |                                                                                                                                                                                                                                                  |                       |                       |                               |                       |                       |                               |             |     |     |    |       |     |     |       |      |    |      |     |      |
| TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%) | <table><tr><td>C</td><td>Si</td><td>Mn</td><td>P</td><td>S</td><td>Cr</td><td>Ni</td><td>Mo</td><td>Cu</td></tr><tr><td>0.015</td><td>0.4</td><td>1.8</td><td>0.015</td><td>0.01</td><td>24</td><td>13.5</td><td>2.6</td><td>0.12</td></tr></table>                                                                                                                                                                                                                                                       |                       | C                     | Si                            | Mn                    | P                     | S                             | Cr          | Ni  | Mo  | Cu | 0.015 | 0.4 | 1.8 | 0.015 | 0.01 | 24 | 13.5 | 2.6 | 0.12 |
| C                                                 | Si                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | Mn                    | P                     | S                             | Cr                    | Ni                    | Mo                            | Cu          |     |     |    |       |     |     |       |      |    |      |     |      |
| 0.015                                             | 0.4                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | 1.8                   | 0.015                 | 0.01                          | 24                    | 13.5                  | 2.6                           | 0.12        |     |     |    |       |     |     |       |      |    |      |     |      |
| ALL WELD MECHANICAL PROPERTIES                    | <table><tr><td>Heat Treatment</td><td>R<sub>P0,2</sub><br/>MPa</td><td>R<sub>m</sub><br/>MPa</td><td>A<sub>5</sub><br/>(%)</td><td>Impact Energy (J) ISO-V<br/>RT</td></tr><tr><td>As Welded /</td><td>370</td><td>540</td><td>32</td><td>60</td></tr></table>                                                                                                                                                                                                                                            |                       | Heat Treatment        | R <sub>P0,2</sub><br>MPa      | R <sub>m</sub><br>MPa | A <sub>5</sub><br>(%) | Impact Energy (J) ISO-V<br>RT | As Welded / | 370 | 540 | 32 | 60    |     |     |       |      |    |      |     |      |
| Heat Treatment                                    | R <sub>P0,2</sub><br>MPa                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | R <sub>m</sub><br>MPa | A <sub>5</sub><br>(%) | Impact Energy (J) ISO-V<br>RT |                       |                       |                               |             |     |     |    |       |     |     |       |      |    |      |     |      |
| As Welded /                                       | 370                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | 540                   | 32                    | 60                            |                       |                       |                               |             |     |     |    |       |     |     |       |      |    |      |     |      |
| REDRYING TEMPERATURE                              | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                       |                       |                               |                       |                       |                               |             |     |     |    |       |     |     |       |      |    |      |     |      |
| GAS ACCORDING EN 14175                            |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                       |                       |                               |                       |                       |                               |             |     |     |    |       |     |     |       |      |    |      |     |      |



# CEWELD SA 309LMo

SA 309LMO 2,0MM

| Type  | KG/unit | EANCode       |
|-------|---------|---------------|
| K-415 | 25      | 8720663414267 |

SA 309LMO 2,4MM

| Type  | KG/unit | EANCode       |
|-------|---------|---------------|
| K-415 | 25      | 8720663414274 |