

# CEWELD SA 309L

**TYPE** Solid drawn stainless steel welding wire for SAW welding. (Type 309L, 23 12 L, 1.4332)

**APPLICATIONS** CEWELD SA 309L is an austenitic SAW solid wire of type S 23 12 L / E309L and is used for SAW welding of dissimilar steels and 13%Cr/18%Cr stainless steels. It is suitable for welding the first layer on low carbon steel to obtain a clad layer AISI 304

**PROPERTIES** CEWELD SA 309L shows high mechanical properties and very good weldability, suitable for operating temperatures up to 300°C. For welding in combination with CEWELD FL 838 and CEWELD FL 880 welding fluxes.

<b>CLASSIFICATION</b>	AWS	A 5.9: ER309L
	EN ISO	14343-A: S 23 12 L
	F-nr	6
	FM	5
	W.Nr.	1.4332

**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** CE

**WELDING POSITIONS**

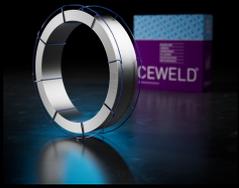


TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	P	S	Cr	Ni	Mo
	0.02	0.55	2	0.02	0.02	24	13	0.2

ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R <sub>p0,2</sub>	R <sub>m</sub>	A <sub>5</sub>	Impact Energy (J) ISO-V RT
	As Welded /	MPa	MPa	(%)	
		370	570	33	100

**REDRYING TEMPERATURE** Not required

**GAS ACCORDING EN 14175**



# CEWELD SA 309L

SA 309L 2,0MM

Type	KG/unit	EANCode
K-415	25	8720663414151

SA 309L 2,4MM

Type	KG/unit	EANCode
K-415	25	8720663414144

SA 309L 3,2MM

Type	KG/unit	EANCode
K-415	25	8720663414120

SA 309L 4,0MM

Type	KG/unit	EANCode
K-415	25	8720663414137