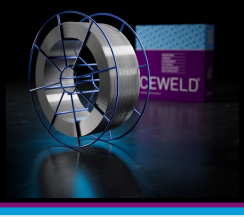


CEWELD 309LMo

certilas® THE FILLER METAL SPECIALIST

TYPE

Solid stainless steel wire for dissimilar welding and cladding.(Type 309LMo, 23 12 2L, 1.4459)

APPLICATIONS

CEWELD 309LMo is a solid, corrosion-resistant '309LMo' type wire used for overlay welding unalloyed and low-alloy steels, as well as dissimilar steels such as 316L to unalloyed and low-alloy steels, where molybdenum (Mo) is essential. It is also used for buffer layers before hard facing and for dissimilar joints between ferritic and austenitic steels, as well as for joining other stainless steel types to standard carbon steel. It is recommended for cladding on low-alloyed steel when AISI 316 is required as the initial layer.

PROPERTIES

CEWELD 309LMo has excellent corrosion resistance in oxidising air up to 950°C. It has good resistance to hot cracking due to its high molybdenum content. During build-up welding, the weld metal achieves the composition of ASTM 316 in the first layer.

CLASSIFICATION

AWS	A 5.9: ER309LMo
EN ISO	14343-A: G 23 12 2 L
F-nr	6
FM	5
W.Nr.	1.4459

SUITABLE FOR

ISO 15608: 8.1 Austenitic ≤ 19 % Cr , TÜV 1000: Gr. 21-30,
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,
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
316Cb, 316L, 316L, 316LN, 316H, 316, 316Ti, 316Cb, 316LN, 321, 410, 444
S31640, S31603, S31653, S31600, S31630, S44400

APPROVALS

CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	Cr	Ni	Mo
0.02	0.5	1.4	24	13	2.5

ALL WELD MECHANICAL PROPERTIES

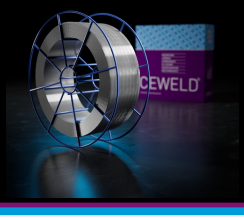
Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)	Impact Energy (J) ISO-V RT	Impact Energy (J) ISO-V -40°C
As Welded /	400	600	31	110	60

REDRYING TEMPERATURE

Not required

GAS ACCORDING EN 14175

M13, M12



CEWELD 309LMo

certilas® THE FILLER METAL SPECIALIST

309LMO 0,8MM

Type	KG/unit	EANCode
BS-300	15	8720663414106
D-100	1	8720663414113

309LMO 1,0MM

Type	KG/unit	EANCode
BS-300	15	8720663414168

309LMO 1,2MM

Type	KG/unit	EANCode
BS-300	15	8720663414175