



CEWELD 309LMo

TYPE	Solid stainless steel wire for dissimilar welding and cladding.(Type 309LMo, 23 12 2L, 1.4459)																	
APPLICATIONS	CEWELD 309MoL is used for build-up welding of non-alloy and low-alloy steels and for welding of dissimilar steels, such as non-alloy and low-alloy steels to high-alloy steels, when Mo plays an essential role.Buffer layers before hard facing, dissimilar joints between ferritic and austenitic steels and or other stainless steel types to standard carbon steel. Recommended for cladding on low alloyed steel in case AISI 316 is required as first layer.																	
PROPERTIES	Excelent corrosion resistance against oxidising air upto 950°C. Good resistance against hot cracking due to the high Mo content. During build-up welding, the weld metal already achieves approximately the composition of ASTM 316 in the 1st layer.																	
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.9: ER309LMo</td> </tr> <tr> <td>EN ISO</td> <td>14343-A: G 23 12 2 L</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>1.4459</td> </tr> </table>	AWS	A 5.9: ER309LMo	EN ISO	14343-A: G 23 12 2 L	F-nr	6	FM	5	W.Nr.	1.4459							
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SUITABLE FOR	<p>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, 444 S31640, S31603, S31653, S31600, S31630, S44400</p>																	
APPROVALS	CE																	
WELDING POSITIONS																		
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> </tr> </thead> <tbody> <tr> <td>0.02</td> <td>0.5</td> <td>1.4</td> <td>24</td> <td>13</td> <td>2.5</td> </tr> </tbody> </table>	C	Si	Mn	Cr	Ni	Mo	0.02	0.5	1.4	24	13	2.5					
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ALL WELD MECHANICAL PROPERTIES	<table border="1"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th>R_{P0,2}</th> <th>R_m</th> <th>A₅</th> <th colspan="2">Impact Energy (J) ISO-V</th> </tr> <tr> <th>MPa</th> <th>MPa</th> <th>(%)</th> <th>RT</th> <th>-40°C</th> </tr> </thead> <tbody> <tr> <td>As Welded /</td> <td>400</td> <td>600</td> <td>31</td> <td>110</td> <td>60</td> </tr> </tbody> </table>	Heat Treatment	R _{P0,2}	R _m	A ₅	Impact Energy (J) ISO-V		MPa	MPa	(%)	RT	-40°C	As Welded /	400	600	31	110	60
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REDRYING TEMPERATURE	Not required																	
GAS ACCORDING EN 14175	M13, M12																	



CEWELD 309LMo

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