CEWELD®

AA 309L

CATEGORY	FCAW Flux-Cored
TYPE	Rutile fluxcored stainless steel welding wire for dissimilar welding
APPLICATIONS	Ceweld AA 309L is used for welding dissimilar steels and 13%Cr/18%Cr stainless steels, and is suitable for welding the first layer on low carbon steel to obtain a AISI 304 clad layer.
PROPERTIES	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. Excellent for use in position and down hand as well. High resistance against moisture pick up.
CLASSIFICATION	AWS A 5.22: E 309-LT0-1 A 5.22: E 309-LT0-4 EN ISO 17633-A: T 23 12 L R M 3 DIN: W.Nr. 1.4332 DIN 8556: 23 12 L
SUITABLE FOR	Buffer layers before hard facing, dissimilar joints between ferritic and austenitic steels and or difficult to weld steels such as: 42CrMo4, C45, 42MnV7, tool steels, heat resistant steels etc.
APPROVALS	TUV (12423.00), LR, CE approved
WELDING POSITIONS:	

ALL-WELD METAL ANALYSES % (TYPICAL)

C	Mn	Si	Cr	Ni	Mo	S	P
0.03	1.30	0.70	23.5	12.5	0.10	0.005	0.018

MECHANICAL PROPERTIES

Gas Type	$R_{P0,2}$ (N/mm^2)	Rm (N/mm^2)	A5 (%)	Impact Energy (J) ISO-V +20°C	-40°C	-60°C	Hardness HRc / HV
M21	440	560	38	>55			

WELDING PARAMETERS PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool	kg / pallet
0.9	19-28	80-150	D-200 - KD-300	5-12,5	1000 / 900
1.2	23-30	150-220	D-200 - KD-300	5-15	1000 / 1080
1.6	25-33	180-280	D-200 - KD-300	5-15	1000 / 1080

REDRYING TEMPERATURE	150ºC / 24hr
GAS ACC. EN ISO 14175:	M21, C1