CEWELD®

AA 309LMoP

CATEGORY	FCAW Flux-Cored
TYPE	Rutile flux cored stainless steel weldig wire for CO2 and M21
APPLICATIONS	Cladding applications in case a AISI 316 is required in the first layer, suitable for dissimilar welding of steel to stainless steel, heat resistant up to 1050 degrees Celsius
PROPERTIES	Flux cored wire with slag support for high productivity welding in all positions. Excellent for use on ceramic backing strips. The slag is self detaching and offers extra protection to obtain X-ray proof weld seams with practically no spatters. Better wetting and welding properties with more productivity compared to solid wires.
CLASSIFICATION	AWS A 5.22:309 Mo L T1-4 EN ISO 17633-A: T 23 12 2 L P M 1 DIN: W.Nr. 1.4459 DIN 8556: 23 13 2 L
SUITABLE FOR	Cladding on low alloyed steels in case a 18/8/2 CrNiMo layer is required in the first layer. 1.4401, 1.4404, 1.4406, 1.4410, 1.4437, 1.4571, 1.4580
APPROVALS	CE approved
WELDING POSITIONS:	

C	Mn	Si	Cr	Ni	Mo	FNW
0.025	0.9	0.55	23	12	2.3	24.2

MECHANICAL PROPERTIES (TYPICAL WITH M21)

Heat Treatment	$R_{P0,2}$ (N/mm^2)	Rm (N/mm^2)	A5 (%)	Impact Energy (J) ISO-V +20°C	-40°C	-60°C	Hardness HRc / HV
AW	400	600	31	110	>60		

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool	kg / pallet
1,2	20-35	130-280	BS-300 / D-200	15 / 5	960 / 1005

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