


AA 309LP

CATEGORY	FCAW Flux-Cored																														
TYPE	Rutile fluxcored stainless steel welding wire for dissimilar welding with fast freezing slag for position welding																														
APPLICATIONS	Ceweld AA 309LP 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. Developped for use in position with maximum slag support. High resistance against moisture pick up.																														
CLASSIFICATION	AWS	A 5.22: E 309 L T 1-4/-1																													
	EN ISO	17633-A: T 23 12 L P M 1																													
	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	LLoyds, CE																														
WELDING POSITIONS:																															
TYPICAL WELD DEPOSIT ANALYSIS (WEIGHT %)	<table border="1"> <thead> <tr> <th>C</th> <th>Mn</th> <th>Si</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> <th>S</th> <th>P</th> </tr> </thead> <tbody> <tr> <td>0.03</td> <td>1.30</td> <td>0.7</td> <td>23.5</td> <td>12.5</td> <td>0.10</td> <td>0.005</td> <td>0.0018</td> </tr> </tbody> </table>							C	Mn	Si	Cr	Ni	Mo	S	P	0.03	1.30	0.7	23.5	12.5	0.10	0.005	0.0018								
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REDRYING TEMPERATURE	150°C/24hr																														
GAS ACC. EN ISO 14175:	M21																														