

SA 309LMo strip

CATEGORY ESAW Electroslag

TYPE Stainless steel strip for cladding overlay applications.

APPLICATIONS Cladding tanks, vessels, tubes etc.

PROPERTIES Latest generation clean melting quality guarantees optimum metallurgical quality and attractive welder appeal. Combined with our high basic electro slag flux **FL 830 ESHC** excellent results are obtained in both deposition rate as minimum delution rate due to the higher slag temperature compare to other electro slag fluxes.

CLASSIFICATION

AWS	A 5.9: ER 309LMo
EN ISO	14343-A: S 23 12 3 L
DIN: W.Nr.	1.4459

SUITABLE FOR Cladding on low alloyed steels in case a 18/8/2 (AISI 316) CrNiMo layer is required in the first layer.

WELDING POSITIONS:



WELD METAL ANALYSIS %

C	Mn	Si	Cr	Ni	Mo
0.015	1.8	0.3	22	14	2.9

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRC / HV
				-20°C	-40°C	-60°C	
AW	450-480	600-700	25-33				

AW: as welded

WELDING PARAMETERS / PACKING

Sizes (mm)	Welding Parameters (ES)			Packing	
	Voltage (V)	Current (A)	kg / coil	internal coil size (mm)	
30 x 0.5	23-25	500-650	25-50	500	
60 x 0.5	23-25	1000-1300	25-50	500	
90 x 0,5	24-26	1400-1900	50-100	500	

REDRYING TEMPERATURE not required