

## SA 309LNb strip

CATEGORY	ESAW Electroslag
TYPE	Chromium-Nickel-Niobium based welding strip.
APPLICATIONS	Boilers, vessels, tube cladding, valves etc.
PROPERTIES	Latest generation clean melting quality guarantees optimum metallurgical quality and attractive welder appeal. Combined with our high basic electro slag flux <b>FL 830 ESHC</b> 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: ~EQ 309LNb
	EN ISO	14343-A: S 23 12 L Nb

**SUITABLE FOR** SA 309LNb is developed for cladding applications in case AISI 347 is required in the first layer on mild steel.

**WELDING POSITIONS:**



**WELD METAL ANALYSIS %**

C	Mn	Si	Cr	Ni	Mo	Nb	Cu	N	S	P
0.05	1.5-2.5	0.1-0.5	20.5-21.5	10.5-11.5	0.3	0.4-0.7	0.2	0.03-0.06	0.03	0.03

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				-20°C	-40°C	-60°C	
AW							

AW: as welded

**WELDING PARAMETERS / PACKING**

Strip size (mm)	Welding Parameters			Packing	
	Voltage (V)	Current (A)	kg / coil	Coil D (mm)	
30 x 0.5	23-25	500-650	25-50	305	
60 x 0.5	23-25	1000-1300	100-125	305	
90 x 0.5	23-25	1450-1800	175-200	305	
120 x 0.5	23-25	1900-2500	175-200	305	

**REDRYING TEMPERATURE** not required