

SAS 309 LMo

CATEGORY ESW Electroslag

TYPE Sintered stainless steel strip for cladding overlay applications.

APPLICATIONS Joining heat resistant CrNi-steels of the same kind and also joining dissimilar alloys such as steel to stainless steel. Cladding on low alloyed steels in case a 18/8/2 CrNiMo layer is required in the first layer.

CLASSIFICATION AWS A 5.9: ~ER 309 LMo
 DIN: W.Nr. 1.4459

SUITABLE FOR Strip cladding on low alloyed steels in case a 18/8/2 CrNiMo (AISI 316) layer is required in the first layer. W.Nr: 1.4401, 1.4404, 1.4406, 1.4410, 1.4437, 1.4571, 1.4580

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 (J)
AW	450-480	600-700	25-33	50-70

AW: as welded

ELECTRO SLAG PARAMETERS / PACKING

Coil D (mm)	Welding Parameters			Packing kg / coil
	Sizes (mm)	Voltage (V)	Current (A)	
500	30 x 0.5	22-25	500-650	25-50
500	60 x 0.5	22-25	1000-1300	25-50

REDRYING TEMPERATURE 150°C / 24hr