

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 **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: ~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.



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 _{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							

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing	
Strip size (mm)	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