

## AA 309L

**CATEGORY** FCAW Flux-Cored

**TYPE** Rutile fluxcored stainless steel welding wire for dissimilar welding

**APPLICATIONS** Ceweld AA 309L 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.  
Excellent for use in position and down hand as well. High resistance against moisture pick up.

**CLASSIFICATION**

AWS	A 5.22: E 309-LT0-1 A 5.22: E 309-LT0-4
EN ISO	17633-A: T 23 12 L R M 3
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** TUV (12423.00), LR, CE approved

**WELDING POSITIONS:**



### ALL-WELD METAL ANALYSES % (TYPICAL)

C	Mn	Si	Cr	Ni	Mo	S	P
0.03	1.30	0.70	23.5	12.5	0.10	0.005	0.018

### MECHANICAL PROPERTIES

Gas Type	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	
M21	440	560	38	>55			

### WELDING PARAMETERS PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool	kg / pallet
0.9	19-28	80-150	D-200 - KD-300	5-12,5	1000 / 900
1.2	23-30	150-220	D-200 - KD-300	5-15	1000 / 1080
1.6	25-33	180-280	D-200 - KD-300	5-15	1000 / 1080

**REDRYING TEMPERATURE** 150°C / 24hr

**GAS ACC. EN ISO 14175:** M21, C1