

## AA 309LP

<b>CATEGORY</b>	FCAW Flux-Cored																														
<b>TYPE</b>	Rutile fluxcored stainless steel welding wire for dissimilar welding with fast freezing slag for position welding																														
<b>APPLICATIONS</b>	Ceweld AA 309LP 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.																														
<b>PROPERTIES</b>	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. Developped for use in position with maximum slag support. High resistance against moisture pick up.																														
<b>CLASSIFICATION</b>	AWS	A 5.22: E 309 L T 1-4/-1																													
	EN ISO	17633-A: T 23 12 L P M 1																													
	DIN: W.Nr.	1.4332																													
	DIN	8556: 23 12 L																													
<b>SUITABLE FOR</b>	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.																														
<b>APPROVALS</b>	LLoyds, CE																														
<b>WELDING POSITIONS:</b>																															
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<b>REDRYING TEMPERATURE</b>	150°C/24hr																														
<b>GAS ACC. EN ISO 14175:</b>	M21																														