


CATEGORY	SAW Arc Submerged																													
TYPE	Stainless steel solid wire for SAW Welding. (Type 309LMo, 23 12 2, 1.4459)																													
APPLICATIONS	Cladding tanks, vessels, tubes etc. Welding dissimilar materials like carbon steel to stainless steels																													
PROPERTIES	CEWELD SA 309LMo is a solid wire for SAW which operates with very stable, spatter free arcs. This wire deposits low carbon weld metal of about 23%Cr-13%Ni-2.3%Mo. Cladding on low alloyed steels, the weld metal already achieves approximately the composition of ASTM 316 in the 1st layer..																													
CLASSIFICATION	AWS	A 5.9: ER309LMo																												
	EN ISO	14343-A: S 23 12 2 L																												
	F-nr	5																												
	FM	6																												
	W.Nr.	1.4459																												
SUITABLE FOR	ISO 15608: 8.1 Austenit ≤ 19 % Cr , TÜV 1000: Gr. 21-30, 1.4583, 1.4435, 1.4436, 1.4404, 1.4406, 1.4408, 1.4401, 1.4571, 1.4580, 1.4406, 1.4521, 1.4301, 1.4306, X102CrNiMoNb 18 12, X2CrNiMo 18 14 3 (TP), X4CrNiMo 17 13 3, X2CrNiMo 17 12 2 (TP), X 5CrNiMo 19 11 2, X4CrNiMo 17 12 2 (TP), X6CrNiMo 17 12 2, X6CrNiMoNb 17 12 3, X2CrNiMoN 17 12 3 (TP), X2CrMoTi18-2 316Cb, 316L, 316L, 316LN, 316H, 316, 316Ti, 316Cb, 316LN, 444 S31640, S31603, S31653, S31600, S31630, S44400																													
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TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> <th>Cu</th> </tr> </thead> <tbody> <tr> <td>0.014</td> <td>0.37</td> <td>1.8</td> <td>0.015</td> <td>0.01</td> <td>23.3</td> <td>13.5</td> <td>2.57</td> <td>0.12</td> </tr> </tbody> </table>					C	Si	Mn	P	S	Cr	Ni	Mo	Cu	0.014	0.37	1.8	0.015	0.01	23.3	13.5	2.57	0.12							
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REDRYING TEMPERATURE	Not required																													
GAS ACCORDING EN 14175																														