



CEWELD AA 309 LP

TYPE	Rutile fluxcored stainless steel welding wire for dissimilar welding with fast freezing slag for position welding.(Type 309L, 23 12 L, 1.4332)										
APPLICATIONS	CEWELD® AA 309 LP is a Rutile austenitic flux-cored wire of type T 23 12 L P / E309LT1 and used for welding dissimilar steels and 13%Cr/18%Cr stainless steels. He is suitable for welding the first layer on low carbon steel to obtain a AISI 304 clad layer. The rapidly solidifying slag offers excellent weldability and slag control in all positions. The easy handling and high deposition rate										
PROPERTIES	CEWELD® AA 309 LP have a 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.										
CLASSIFICATION	AWS	A 5.22: E309LT1-1, A 5.22: E309LT1-4									
	EN ISO	17633-A: T 23 12 L P M21 2									
	W.Nr.	1.4332									
	F-nr	6									
	FM	5									
SUITABLE FOR	ISO 15608: 8.1 Austenitic ≤ 19 % Cr , TÜV 1000: Gr. 21-30, 23% Cr, 12%Ni Type 1.2780, 1.4541, 1.4550, 1.4710, 1.4712, 1.4713, 1.4724, 1.4729, 1.4740, 1.4741, 1.4742, 1.4746, 1.4762, 1.4745, 1.4825, 1.4826, 1.4828, 1.4832, 1.4878, X15CrNiSi20 12, G-X 40 CrNiSi20 9, AISI 446, AISI442, AISI309, UNS S30900, S44200, S44600										
APPROVALS	CE, Lloyds, DNV										
WELDING POSITIONS											
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	P	Cr	Ni	Mo	S	FN	FS	FNW
	0.026	0.86	1.4	0.021	23.5	13	0.15	0.006	17	12	14.7
MECHANICAL PROPERTIES	Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A5 (%)	Impact Energy (J) ISO-V				Hardness		
					-20°C				-60°C		
	As Welded	460	580	38	75				45		HRc
REDRYING	140°C / 24 hr										
GAS ACC. EN ISO 14175	M21										



CEWELD AA 309 LP

AA 309 LP 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663413772
D-200	5	8720663413758
D-270	15	8720663424631