



CEWELD AA 309LP

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	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	<table border="0"> <tr> <td>AWS</td> <td>A 5.22: E309LT1-1</td> </tr> <tr> <td>EN ISO</td> <td>17633-A: T 23 12 L P M21 2</td> </tr> <tr> <td>W.Nr.</td> <td>1.4332</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>5</td> </tr> </table>	AWS	A 5.22: E309LT1-1	EN ISO	17633-A: T 23 12 L P M21 2	W.Nr.	1.4332	F-nr	6	FM	5												
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SUITABLE FOR	<p>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</p>																						
APPROVALS	CE, Lloyds, DNV																						
WELDING POSITIONS																							
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> <th>S</th> <th>FN</th> <th>FS</th> <th>FNW</th> </tr> </thead> <tbody> <tr> <td>0.026</td> <td>0.86</td> <td>1.4</td> <td>0.021</td> <td>23.5</td> <td>13</td> <td>0.15</td> <td>0.006</td> <td>17</td> <td>12</td> <td>14.7</td> </tr> </tbody> </table>	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
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		-20°C	-60°C																				
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REDRYING	140°C / 24 hr																						
GAS ACC. EN ISO 14175	M21																						



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AA 309LP 1,2MM

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