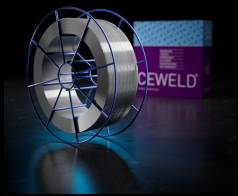


# CEWELD 309LSi

|                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                         |                      |                    |                         |        |
|---------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------|----------------------|--------------------|-------------------------|--------|
| TYPE                                              | Solid stainless steel welding wire for dissimilar welding. ( Type 1.4432, 23 12 LSi )                                                                                                                                                                                                                                                                                                                                                                                                                |                         |                      |                    |                         |        |
| APPLICATIONS                                      | CEWELD 309LSi is for buffer layers before hard facing, dissimilar joints between ferritic and austenitic steels and or difficult to weld steels.                                                                                                                                                                                                                                                                                                                                                     |                         |                      |                    |                         |        |
| PROPERTIES                                        | High mechanical properties and very good weldability due to a ingreased silicon content, suitable for operating temperatures from -120°C up to 300°C.                                                                                                                                                                                                                                                                                                                                                |                         |                      |                    |                         |        |
| CLASSIFICATION                                    | AWS                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | A 5.9: ER309LSi         |                      |                    |                         |        |
|                                                   | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               | 14343-A: G 23 12 L Si   |                      |                    |                         |        |
|                                                   | W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | 1.4332                  |                      |                    |                         |        |
|                                                   | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | 6                       |                      |                    |                         |        |
|                                                   | FM                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | 5                       |                      |                    |                         |        |
| SUITABLE FOR                                      | <b>ISO 15608: 8.1 Austenitic ≤ 19 % Cr ( no Mo)</b><br><b>ISO 15608: Gr. 8.1 mix 1.1</b><br>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,<br>X15CrNiSi20 12, G-X 40 CrNiSi20 9,<br>AISI 446, AISI442, AISI309,<br>UNS S30900, S44200, S44600                                                                                                                                               |                         |                      |                    |                         |        |
| APPROVALS                                         | TÜV: (12395), CE                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                         |                      |                    |                         |        |
| WELDING POSITIONS                                 | <div> PA</div> <div> PB</div> <div> PC</div> <div> PD</div> <div> PE</div> |                         |                      |                    |                         |        |
| TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | Si                      | Mn                   | Cr                 | Ni                      |        |
|                                                   | 0.02                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | 0.8                     | 1.8                  | 24                 | 13                      |        |
| MECHANICAL PROPERTIES                             | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | R <sub>p0.2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V |        |
|                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                         |                      |                    | RT                      | -196°C |
|                                                   | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | 515                     | 610                  | 37                 | 130                     | 45     |
|                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                         |                      |                    |                         | HRc    |
| REDRYING                                          | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                         |                      |                    |                         |        |
| GAS ACC. EN ISO 14175                             | M11, M13, M12                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                         |                      |                    |                         |        |



# CEWELD 309LSi

## 309LSi 0,8MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663413857 |
| D-100     | 1       | 8720663413864 |
| D-200     | 5       | 8720663413871 |

## 309LSi 1,0MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663413888 |
| D-200     | 5       | 8720663413932 |
| Drum      | 250     | 8720663413895 |

## 309LSi 1,2MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663413901 |
| D-200     | 5       | 8720663413918 |
| Drum      | 250     | 8720663413925 |

## 309LSi 1,6MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663413956 |