



CEWELD SA 308L strip

TYPE Stainless steel strip for ESW

APPLICATIONS Cladding surfaces

PROPRIÉTÉS Strip with 19Cr/9Ni composition, ESW process has very low dilution so in the first layer you almost reach the chemical composition. Flux FL 860 ESH can be used.

CLASSIFICATION

AWS	A 5.9: EQ308L
EN ISO	14343-A: B 19 9 L
FM	1.4316

CONVIENT POUR

ISO 15608: 8.1 Austenitic $\leq$ 19 % Cr 9% Ni, TÜV 1000: Gr. 21 - 22 (29 max.350°C),
1.4301, 1.4306, 1.4307, 1.4308, 1.4311, 1.4312, 1.6900, 1.6901, 1.6902, 1.6903, 1.9606, 1.4541, 1.4546, 1.4550
X 5 CrNi 18 10, X 2 CrNi 19 11, X 5 CrNi 18 9, G-X 6 CrNi 18 9, X 12 CrNi 18 9, G-X 8 CrNi 18 10, X 6 CrNi 18 10, X 10 CrNiTi 18 10, X 5 CrNi 18 10
AISI 304, 304H, 312, 321H, 347, 347H,
UNS S30409, S32109, S34709, S30400, S32100, S34700

AGRÉMENTS CE

POSITIONS DE SOUDAGE



ANALYSE CHIMIQUE
TYPIQUE DU MÉTAL
D'APPORT (%)

C	Si	Mn	P	S	Cr	Ni	Mo
0.02	0.55	2	0.02	0.01	21	10	0.5

PROPRIÉTÉS MÉCANIQUES

Heat Treatment	R _{p0.2} (MPa)	R _m (MPa)	A5 (%)	Hardness
As Welded	450	600	>35	HRc

ETUVAGE Not required

GAS ACC. EN ISO 14175