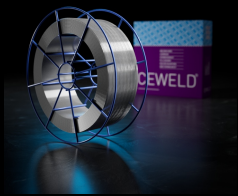


CEWELD 309LSi

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	ISO 15608: 8.1 Austenitic ≤ 19 % Cr ISO 15608: Gr. 8.1 mix 1.1 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	TÜV: (12395), CE					
WELDING POSITIONS	 PA  PB  PC  PD  PE					
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 _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	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