



CEWELD SA 309LNb strip

TYPE Solid stainless steel welding strip

APPLICATIONS Boilers, vessels, tube cladding, valves etc.

PROPRIÉTÉS Latest generation clean melting quality guarantees optimum metallurgical quality and attractive welder appeal. Combined with our high basic electro slag flux FL 830 ESHC excellent results are obtained in both deposition rate as minimum delution rate due to the higher slag temperature compare to other electro slag fluxes.

CLASSIFICATION

AWS	A 5.9: EQ309LNb~
EN ISO	14343-A: B 22 12 L Nb
W.Nr.	1.4556

CONVIENT POUR SA 309LNb is developed for cladding applications in case AISI 347 is required in the first layer on mild steel.

AGRÉMENTS CE

POSITIONS DE SOUDAGE



ANALYSE CHIMIQUE
TYPIQUE DU MÉTAL
D'APPORT (%)

C	Si	Mn	P	S	Cr	Ni	Nb
0.05	0.5	2	0.02	0.02	24	12.5	0.6

PROPRIÉTÉS MÉCANIQUES

Heat Treatment	R _{p0.2} (MPa)	R _m (MPa)	A5 (%)	Hardness
As Welded	450	600	>30	HRc

ETUVAGE Not required

GAS ACC. EN ISO 14175