

ASME II C SFA 5.9 :	EQ 309L
EN ISO 14343-A :	B 23 12 L
EN ISO 14343-B :	BS309L

DESCRIPTION

- SOUDOTAPE 309L is a strip specially developed to be used, in combination with Record INT 101 or Record INT 109 (SAW) and Record EST 122 or Record EST 136 (ESW).
- In most cases it is used for the cladding of a buffer layer prior to cladding with strips such as SOUDOTAPE 308L, 316L and 347.

SUITABLE FOR

- Used in a wide variety of industries such as chemical, petrochemical...
- Typical applications are reactor vessels, hydrocracker...

TYPICAL WELD METAL ANALYSIS OF STRIP/FLUX COMBINATION (WEIGHT%)

- Submerged arc strip cladding with RECORD INT 101 / INT 109 on a 0.2 % C-steel.

	Flux RECORD	C	Mn	Si	Cr	Ni	Thickn (mm)	FN
SOUDOTAPE 309L		0.012	1.80	0.40	23.70	13.30	-	-
1 st Layer	INT 101	0.037	1.60	0.80	19.70	10.70	4.2	6
1 st Layer	INT 109	0.045	0.90	0.80	19.30	10.60	4.5	4

- Electroslag strip cladding with RECORD EST 122 / EST 136 on 0.2 % C-steel.

	Flux RECORD	C	Mn	Si	Cr	Ni	Thickn. (mm)	FN
SOUDOTAPE 309L		0.012	1.80	0.40	23.70	13.30	-	-
1 st Layer	EST 122	0.035	1.30	0.60	19.20	10.60	4.9	6
1 st Layer	EST 136	0.050	1.50	0.50	18.40	10.20	3.1	2

AVAILABLE STRIP SIZES

- Standard : 60 x 0.5 mm or 30 x 0.5 mm.
- Other sizes on request.

PACKING

- 60 x 0.5 mm : 50 kg to 60 kg.
- 30 x 0.5 mm : 25 kg to 30 kg.
- Other sizes on request.

Note : For additional information about cladding conditions and deposited weld metal properties, please refer to the corresponding flux technical data sheet, cladding data sheet or contact us.