

Data sheet and application

DIM L-1.4459[©]

Material no.: 1.4459

DIN 8556: SG X 2 25 13 3

EN ISO 14343-A: G/W Z 25 13 3

EN 12072: G/W 23 12 2 L

AWS A5.9: ~ER 309 L Mo

Non-rusting CrNiMo welding filler material

Characteristics

High-alloyed wire electrode for plating, various steels and austenite-ferrite connections up to 300°C operating temperature.

For hard-weldable steels. Black and white connections.

Welding of buffer layers / welding of sheet metal. High polishable.

Base materials

1.4301 - X 5 CrNi 18-10 (X 5 CrNi 18-9),
 1.4306 - X 2 CrNi 19-11 (X 2 CrNi 18-9),
 1.4308 - GX 6 CrNi 18-9,
 1.4311 - X 2 CrNiN 18-10,
 1.4401 - X 5 CrNiMo 17-12-2 (X 5 CrNiMo 18-10),
 1.4404 - X 2 CrNiMo 17-13-2 (X 2 CrNiMo 18-10),
 1.4406 - X 2 CrNiMoN 17-12-2,
 1.4408 - GX 6 CrNiMo 18-10,
 1.4435 - X 2 CrNiMo 18-14-3 (X 2 CrNiMo 18-12),
 1.4436 - X 5 CrNiMo 17-13-3 (X 5 CrNiMo 18-12),
 1.4541 - X 6 CrNiTi 18-10,
 1.4550 - X 6 CrNiNb 18-10 (X 10 CrNiNb 18-9),
 1.4552 - GX 5 CrNiNb 18-9,
 1.4571 - X 6 CrNiMoTi 17-12-2,
 1.4573 - X 10 CrNiMoTi 18-12,
 1.4580 - GX 10 CrNiMoNb 18-10,
 1.4581 - GX 5 CrNiMoNb 18-10,
 1.4583 - X 10 CrNiMoNb 18-12,
 1.4948 - X 6 CrNi 18-11,
 S31653, AiSi 316 L, 316 Ti, 316 Cb
 1.4057 - X 17 CrNi 16-2

All among each other or with un- or low alloyed steels.

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Chemical composition

C	Si	Mn	Cr	Ni	Mo	Fe
0,02	0,4	1,5	22,0	14,5	2,5	Remainder

Certificate of batch upon request.

Mechanical properties of pure weld metal

Yield strength Re	Tensile strength Rm MPa	Elongation (A)(Lo=5do)	Impact energy (Av)
500 N/mm ²	700 N/mm ²	30 %	60 J

Hardness of pure weld metal	Coolness after hot/ cold hardening
approx. 220 HB	approx. 38 HRC