



DAIKOSTRIP 309L

SAW - ESW

AUSTENITIC STAINLESS STEELS

309L

PRODUCT DESCRIPTION

Cladding strip 309L alloy.

Used for cladding applications to deposit a single layer type 308L alloy. It also be suitable as buffer layer to deposit 2 layers overlay in combination with DAIKOSTRIP 308L.

Typical applications include cladding of tanks and vessels for chemical, petrochemical and refinery industries.

SPECIFICATIONS

| | |
|----------------|----------------------|
| AWS A5.9 | EQ309L |
| EN ISO 14343-A | B 23 12 L/2113 L |
| DIN | - |
| Approvals | - |
| Shielding | DAIKOFLUX 930, 937AS |

ASME IX QUALIFICATION

| | |
|--------------|---|
| F-No (QW432) | 6 |
| A-No (QW442) | 8 |

FERRITE

8-15 FN

PREN

25

HARDNESS

85 HRB

Typical Strip Composition (weight %)

| C | Mn | Si | S | P | Cr | Ni | Mo | Cu |
|-------|------|------|-------|-------|-------|-------|------|------|
| 0.009 | 1.83 | 0.35 | 0.001 | 0.011 | 23.64 | 13.15 | 0.27 | 0.14 |

Typical surface composition

| | |
|---------------|---------------|
| Base Material | Carbon Steel |
| Process | Electroslag |
| Flux | DAIKOFLUX 930 |

| | C | Cr | Ni | Mn | Si | FN (WRC-92) |
|-----------|------|---------|----------|-----|------|-------------|
| 1st layer | 0.03 | 18 - 20 | 9.5 - 11 | 1.4 | 0.40 | 3-8 |