

Classification

AWS A 5.4: E 316L- 16

DIN 8556: E 19 12 3 LR 23

DIN EN 1600: E 19 12 3 L 32

Werkstoff Nr: 1.4430

Description and applications

Low carbon Rutile-basic-coated Mo containing austenitic stainless steel electrode with approx 5-9% ferrite. Coating with very low moisture pick-up. Soft fusion, without spatters, very easy slag removal, exceptional bead appearance, easy restriking. Packed in vacpack system. For welding and cladding on austenitic Cr-Ni-Mo stainless steels and clad plates. Applied for service temperatures from -120°C up to +400° C in the chemical and petrochemical industries, in refineries, in the food industries and for ship building to weld pipes, tanks, heat exchangers.

Base materials

Stainless steels for general use:

UNS	Alloy	EN 10088	Material N°	UGINE
S31600	316	X5CrNiMo17-12-2	1.4401	UGINOX 17-10 M
S31603	316L	X2CrNiMo17-12-2	1.4404	UGINOX 18-11 ML
J92900		G-X5CrNiMo19-11-2	1.4408	
S31635	316Ti	X6CrNiMoTi17-12-2	1.4571	UGINOX 17-11 MT
S31635	316Ti	X10CrNiMoTi18-12	1.4573	
S31640	316Cb	X6NiCrMoNb17-12-2	1.4580	
		G-X5CrNiMoNb19- 11-12	1.4581	

All weld metal mechanical properties (typical)

Tensile strength Rm (N/mm2)

590

Elongation (%)

37

ISO- V (J) RT

60

Typical weld metal chemical composition (%)

C

0.026

Si

0.90

Mn

0.75

Cr

18.50

Ni

12.00

Mo

2.40

S

0.010

P

0.025

Amperes (A)

2.50

50-80

3.15

80-110

4.00

100-150

5.00

150-180

Welding instruction

Redrying 1 h at 250° C if necessary. Interpass temperature: <200°C.



1G/PA



2F/PB



2G/PC



3G/PF



4G/PE

