CEWELD AA 316LM

certilas® THE FILLER METAL SPECIALIST

TYPE

Metal cored stainless steel welding wire. (Type 19 2 3LM, 1.4430)

APPLICATIONS

CEWELD AA316LM is suitable for welding stainless steels with an alloy content between 16 to 21% Cr, 6 to 13% Ni and up to 3% Mo, stabilised and unstabilised types Widely used in the chemical and food-processing industries, as well as in shipbuilding and various types of architectural structure.

PROPERTIES

CEWELD AA316LM offers good general corrosion resistance, particularly to corrosion in acid and chlorinated environments. Low carbon deposit. Enhanced productivity, improved weldability, better wetting properties compared to solid wires. Excellent weld metal quality and X-ray soundness.

CLASSIFICATION

AWS	A 5.22: EC316L
EN ISO	17633-A: T 19 12 3 L M M12 1
W.Nr.	1.4430
F-nr	6
FM	5

SUITABLE FOR

ISO 15608: 8.1 Austenitic ≤ 19 % Cr , TÜV 1000: Gr. 21-30,
1.4583, 1.4435, 1.4436, 1.4404, 1.4406, 1.4408, 1.4401, 1.4571, 1.4580, 1.4406, 1.4521, 1.4430
X102CrNiMoNb 18 12, X2CrNiMo 18 14 3 (TP), X4CrNiMo 17 13 3, X2CrNiMo 17 12 2 (TP), X 5CrNiMo 19 11 2, X4CrNiMo 17 12 2 (TP), X6CrNiMo 17 12 2, X6CrNiMoNb 17 12 3, X2CrNiMoN 17 12 3 (TP), X2CrMoTi18-2
AISI 316Cb, 316, 316L, 316LN, 316H, 316Ti, 316Cb, 316LN, 318, 444
UNS S31640, S31603, S31653, S31600, S31630, S44400, S31635, S31640

APPROVALS

CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S	Cr	Ni	Mo
0.02	0.6	1.4	0.02	0.008	20	12	3

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V -60°C	Hardness
As Welded	450	610	35	40	HRc

REDRYING

Not required

GAS ACC. EN ISO 14175

I1, M13, M12