



CEWELD 316LMn

TYPE	Solid welding wire for welding fully austenitic CrNiMnMo stainless steels and low temperature steels.						
TOEPASSINGEN	Particularly suited for corrosion conditions in urea synthesis plants for welding work on steel X 2 CrNiMo 18 12 and for over-lay claddings of Type 1.4455.. Well suited for joining and cladding applications with matching and similar austenitic CrNi(N) and CrNiMo(Mn,N) steels/cast steel grades.						
EIGENSCHAPPEN	Stainless steel with excellent resistance to intercrystallin corrosion and wet corrosion up to 350°C (662 °F). Corrosion-resistance is similar to low-carbon CrNiMo (Mn,N) steels/cast steel grades. Seawater resistant, good resistance to nitric acid, selective attack max. 200 µm. Non magnetic (permeability in field of 8000 A/m 1.01 max.).						
CLASSIFICATIE	AWS	A 5.9: ER316LMn					
	EN ISO	14343-A: G 20 16 3 Mn N L					
	W.Nr.	1.4455					
	F-nr	6					
	FM	5					
GESCHIKT VOOR	ISO 15608: 8.1 Austenitic ≤ 19 % Cr 1.3941, 1.3945, 1.3948, 1.3951, 1.3952, 1.3953, 1.3955, 1.3964, 1.3965, 1.4315, 1.4401, 1.4404, 1.4411, 1.4429, 1.4435, 1.4438, 1.4439, 1.4449, 1.4561, 1.4571, 1.6902, 1.6903, 1.6905, 1.5662, X5 CrNiMo 17-12-2, X2CrNiMoN 22-15, X2CrNiMoN 18-14-3, X2CrNiMo 18-15, X8 CrMnNi 18-8, X2 CrNiMo 17-13-2, X2 CrNiMo 18-14-3, X2CrNiMoN 17-13-3, X6 CrNiMoTi 17-12-2, X2 CrNiMoN 17-13-5, X3 CrNiMo 18-12-3, X2 CrNiMo 18-15-4, X2 CrNiN 18-10, GX6 CrNi 18-10, GX5 CrNiNb 18-10, X5CrNiN19-9, X1CrNiMoTi18-13-2, 10CrNiTi18-10, (G)X4CrNi18-3, X2CrNiN18-13, X4CrNiMnMoN19-13-8, UNS S31600, S31603, S31635, S31700, S31703, S30453 AISI 316, 316L, 316Ti, 317, 317L, 304LN 3,5 – 5% Ni-Steel						
GOEDKEURINGEN	CE						
LASPOSITIES							
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	Cr	Ni	Mo	N
	0.015	0.5	7	20	17	3	0.01
MECHANISCHE WAARDEN	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
					-196°C		
	As Welded	430	650	35	50		HRc
HERDROGEN	Not required						
GAS ACC. EN ISO 14175	M11, M13, M12						



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316LMN 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663424587