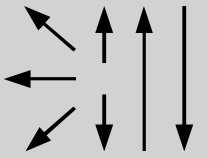


Classifications						
EN ISO 14343-A	EN ISO 14343-B	AWS A5.9	(Mat. No.)			
G 19 12 3 L	SS316L	ER316L	(1.4430)			
Characteristics and typical fields of application						
Austenitic stainless steel wire electrode, resistant to inter-crystalline corrosion, Corrosion-resistance similar to matching low-carbon and stabilized austenitic 17/12/2-CrNiMo steels / cast steel grades. For joining application with matching and similar – non-stabilized – austenitic CrNi(N) and CrNiMo(N) steels and cast steel grades.						
Base materials						
TÜV-certified parent metal 1.4401 – X5CrNiMo17-12-2; 1.4404 – X2CrNiMo17-12-2; 1.4435 – X2CrNiMo18-14-3; 1.4436 – X3CrNiMo17-13-3; 1.4571 – X6CrNiMoTi17-12-2; 1.4580 – X6CrNiMoNb17-12-2; 1.4583 – X10CrNiMoNb18-12; 1.4409 – GX2CrNiMo19-11-2; UNS S31603, S31653; AISI 316L, 316Ti, 316Cb						
Typical analysis of solid wire (wt.-%)						
	C	Si	Mn	Cr	Mo	Ni
wt-%	0.02	0.8	1.7	18.8	2.8	12.5
Structure: Austenite with part ferrite						
Mechanical properties of all-weld metal						
Heat-treatment	Yield strength R _{p0.2}	Yield strength R _{p1.0}	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact work ISO-V CVN J	
	MPa	MPa	MPa	%	+20 °C	
aw	380	420 (≥ 320)	560 (≥ 510)	35 (≥ 25)	70	
Operating data						
	Polarity: DC (+)	Shielding gas: (EN ISO 14175) M12, M13		ø mm 0.8 1.0 1.2	Spool: BS300 B300 Drum	
Welding instruction						
Materials			Preheating	Postweld heat treatment		
Matching and similar non-stabilized and stabilized steels / cast steel grades			None	Mostly none. If necessary, solution annealing at 1050°C (1922°F) – pay attention to tendency to embrittlement		
Approvals						
TÜV (09500), DB (43.132.20), DNV-GL, CE						