

Standards :

TS EN ISO 3581 - A	: E 19 12 3 LB 22
EN ISO 3581 - A	: E 19 12 3 LB 22
AWS A5.4	: E 316 L-15

**Chemical Composition of Weld Metal-
% (Typical) :**

C	Si	Mn	Mo	Ni	Cr
0.03	0.45	1.35	2.75	11.5	18.9

Mechanical Properties :

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/+20 °C)	Elongation (L ₀ =5d ₀)(%)
min. 360	550-700	min.55 J	min. 35

Typical Base Material Grades :

* X10CrNiMoNb 18 12, X2CrNiMo 18 14 3, X5CrNiMo 17 13 3, X2CrNiMo 17 13 2, X2CrNiMoN 17 12 2, X5NiMo 17 12 2, X5CrNiMoTi 17 12 2, X6CrNiMoNb 17 12 2, X2CrNiMoN 17 13 3, 316 L, 316, 316 Cb, 316 Ti

Features and Applications :

* Low-carbon alloyed-core wire austenitic electrode with basic coating for use in all industries where analogous steels, including higher carbon grades and ferritic 13% Cr types, are welded. High ductility of weld metal, therefore preferably used for welding of heavy sections. Very good out-of-position weldability. Good low-temperature ductility down to -196°C. Resistance to intergranular corrosion up to 400°C. * No requirement of preheating or postweld heat treatment of weld metal.

* Re-drying : 150 - 200°C / 2 h

Welding Positions :



Current Type :

D.C.(+)

Operating Data :

Diameter x Length (mm)	Diameter x Length (inch)	Welding Current (A)	Weight g /100 pcs
2.50 x 250	3/32 x 10"	60-80	1440
3.20 x 350	1/8 x 14"	80-110	3520
4.00 x 350	5/32 x 14"	110-140	4570

Approvals :

TSE, CE, GOST-R, SEPRO