



# CEWELD 316LMn Tig

**TYPE** Tig filler metal for welding fully austenitic CrNiMnMo stainless steels and low temperature steels. (Type 19 12 3Mn, 1.4455)

**APPLICATIONS** 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.

**PROPERTIES** Stainless steel with excellent resistance to intercrystalline 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.).

**CLASSIFICATION**

AWS	A 5.9: ER316LMn
EN ISO	14343-A: W 20 16 3 Mn N L
W.Nr.	1.4455
F-nr	6
FM	5

**SUITABLE FOR** **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

**APPROVALS** CE

**WELDING POSITIONS**

**TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)**

C	Si	Mn	P	S	Cr	Ni	Mo	N
0.02	0.55	7.5	0.01	0.01	20	16	3	0.01

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>P0.2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness
				RT		
As Welded	440	620	35	120		HRc

**REDRYING** Not required

**GAS ACC. EN ISO 14175** I1



# CEWELD 316LMn Tig

316LMN TIG 1,6 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663414984

316LMN TIG 2,0 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663415028

316LMN TIG 2,4 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663415066