

# CEWELD AA 316L

**TYPE** Flux cored stainless steel welding wire for AISI 316. (Type 19 12 3 L, 1.4430)

**APPLICATIONS** Boilers, shipbuilding, machinery, offshore application, foundries, chemical industry, orbital tube welding etc.

**PROPERTIES** Flux cored wire with slag support for high productivity. Excellent for use on ceramic backing strips. The slag is self detaching and offers extra protection to obtain X-ray proof weld seams with practically no spatters. Better wetting and welding properties with more productivity compared to solid wires. The 0,9 and 1,0 mm can be used for all positions including vertical down and is classified as: AWS A 5.22: E 316-LT1-4

**CLASSIFICATION**

AWS	A 5.22: E316LT0-1
EN ISO	17633-A: T 19 12 3 L R M21 3
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, 1.4301, 1.4306,  
 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  
 316Cb, 316L, 316L, 316LN, 316H, 316, 316Ti, 316Cb, 316LN, 444  
 S31640, S31603, S31653, S31600, S31630, S44400

**APPROVALS** CE, TÜV: TÜV (12424.00)

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

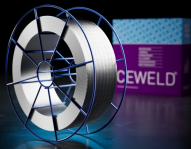
C	Si	Mn	Cr	Ni	Mo	Cu
0.028	0.51	1.63	18.9	12.1	2.75	0.11

**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	-110°C	
As Welded	380	525	45	55	35	HRC

**REDRYING** 140°C / 24 hr

**GAS ACC. EN ISO 14175** M21



# CEWELD AA 316L

## AA 316L 0,9MM

Packaging	KG/unit	EanCode
BS-300	12,5	8720663413352
D-200	4,5	8720663413437

## AA 316L 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663413505
BS-300	12.5	8720663413512
D-200	5	8720663413567

## AA 316L 1,6MM

Packaging	KG/unit	EanCode
BS-300	17	8720663413536