



CEWELD 316LMn

TYPE	Solid welding wire 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 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.).													
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.9: ER316LMn</td> </tr> <tr> <td>EN ISO</td> <td>14343-A: G 20 16 3 Mn N L</td> </tr> <tr> <td>W.Nr.</td> <td>1.4455</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>5</td> </tr> </table>	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			
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SUITABLE FOR	<p>ISO 15608: 8.1 Austenitic ≤ 19 % Cr</p> <p>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,</p> <p>UNS S31600, S31603, S31635, S31700, S31703, S30453</p> <p>AISI 316, 316L, 316Ti, 317, 317L, 304LN</p> <p>3,5 – 5% Ni-Steel</p>													
APPROVALS	CE													
WELDING POSITIONS														
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> </tr> </thead> <tbody> <tr> <td>0.015</td> <td>0.5</td> <td>7</td> <td>20</td> <td>17</td> <td>3</td> </tr> </tbody> </table>	C	Si	Mn	Cr	Ni	Mo	0.015	0.5	7	20	17	3	
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		-196°C												
As Welded	430	650	35	50	HRc									
REDRYING	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