



# CEWELD AA 316LM

**TYPE** Metal cored stainless steel welding wire. ( Type 19 2 3LM, 1.4430)

**APPLICATIONS** CEWELD AA316LM is suitable for welding stainless steels with an alloy content between 16 to 21% Cr, 6 to 13% Ni and up to 3% Mo, stabilised and unstabilised types Widely used in the chemical and food-processing industries, as well as in shipbuilding and various types of architectural structure.

**PROPERTIES** CEWELD AA316LM offers good general corrosion resistance, particularly to corrosion in acid and chlorinated environments. Low carbon deposit. Enhanced productivity, improved weldability, better wetting properties compared to solid wires. Excellent weld metal quality and X-ray soundness.

**CLASSIFICATION**

AWS	A 5.22: EC316L
EN ISO	17633-A: T 19 12 3 L M M12 1
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, 1.4430  
 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  
 AISI 316Cb, 316, 316L, 316LN, 316H, 316Ti, 316Cb, 316LN, 318, 444  
 UNS S31640, S31603, S31653, S31600, S31630, S44400, S31635, S31640

**APPROVALS** CE

**WELDING POSITIONS**

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

C	Si	Mn	P	S	Cr	Ni	Mo
0.02	0.6	1.4	0.02	0.008	20	12	3

**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
				-60°C	
As Welded	450	610	35	40	HRc

**REDRYING** Not required

**GAS ACC. EN ISO 14175** I1, M13, M12