

Standards :

TS EN ISO 3581 - A	:	E 19 12 3 LR 32
EN ISO 3581 - A	:	E 19 12 3 LR 32
AWS A5.4	:	E 316 L-16

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

C	Si	Mn	Mo	Ni	Cr
0.03	0.8	0.9	2.6	11.5	19.0

Mechanical Properties :

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/+20 °C)	Elongation (L _o =5d _o)(%)
min. 355	540-670	min.47 J	min. 30

Typical Base Material Grades :

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

Features and Applications :

* Tanks, pipes and equipments made of Cr-Ni-Mo low-carbon steels which are used in food, textile, chemical and paint industries.

* Weld metal is resistant to acid, corrosion.

* Serviceability at temperatures up to 400 °C.

* Re-drying : 300 °C / min. 2 h

Welding Positions :



Current Type :

D.C.(+)

A.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"	50-90	1570
3.20 x 350	1/8 x 14"	80-120	3470
4.00 x 350	5/32 x 14"	110-160	5200

Approvals :

TSE, BV, CE, ABS, GOST-R, SEPRO, HAKC (3.20 mm)