



## Solid Mig/Tig filler metal

### Ceweld 316LSi

**Type:** Stainless steel welding wire developed for welding stabilized austenitic CrNiMo(N) types.

<b>Base metals:</b>	1.4583	X102CrNiMoNb 18 12	316Cb
	1.4435	X2CrNiMo 18 14 3	(TP) 316L
	1.4436	X4CrNiMo 17 13 3	-
	1.4404	X2CrNiMo 17 12 2	(TP) 316L
	1.4401	X4CrNiMo 17 12 2	(TP) 316
	1.4571	X6CrNiMo 17 12 2	316 Ti
	1.4580	X6CrNiMoNb 17 12 3	316Cb
	1.4406	X2CrNiMoN 17 12 3	(TP)316LN

**Properties:** Excellent corrosion resistance up to 400°C and good weldability with excellent flowing properties due to the increased Si content.

<b>Standards:</b>	AWS SFA 5.9	: ER 316 LSi
	W.Nr.	: 1.4430
	DIN 8556	: SG-X2CrNiMo 19 12
	EN 12072	: G 19 12 3 LSi

**Welding positions :** according ISO 6947: PA, PB, PC, PD, PE, PF, PG

**Shielding gas :** according EN 439: M12, - 13

#### Analyses %

C	Mn	Si	Cr	Ni	Mo
<0.02	1.7	0.8	18.8	12.5	2.8

#### Mechanical properties

R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact strenght ISO-V-J	
			+20 °C	- 196 °C
>380	>560	>35	>70	-

**Sizes:** Mig: 0,8 mm, 1,0 mm, 1,2 mm, 1,6 mm  
Tig: 1,0 – 1,2 – 1,6 – 2,0 – 2,4 - 3,2 mm x 1000 mm

**Package:** Mig: K-300, D-300, S-300, Drum, B3  
Tig: 5 kg cartons

**Current Type:**  
Mig DC +  
Tig DC -

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