Solid Mig/Tig filler metal

Ceweld 316LSi

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

Base metals:

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.

Standards:

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

$R_{P0,2}$ (N/mm²)	R_m (N/mm²)	A_5 (%)	Impact strenght ISO-V-J +20 °C	Impact strenght ISO-V-J - 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 -