

## Classifications

EN ISO 14343-A	AWS A5.9 / SFA-5.9
S 19 12 3 L	ER316L

## Characteristics and typical fields of application

Solid wire of S 19 12 3 L / ER316L type for joining and surfacing application with matching and similar non-stabilized austenitic CrNi(N) and CrNiMo(N)-steels and cast steel grades. Corrosion resistance similar to matching low-carbon and stabilized austenitic CrNiMo-steels and cast steel grades. Resistant to intercrystalline corrosion and wet corrosion up to 400°C.

### Recommended SAW flux:

Marathon 104  
 Marathon 213  
 Marathon 431

## Base materials

1.4401 X5CrNiMo17-12-2, 1.4404 X2CrNiMo17-12-2, 1.4409 GX2CrNiMo19-11-2, 1.4429 X2CrNiMoN17-12-3, 1.4432 X2CrNiMo17-12-3, 1.4435 X2CrNiMo18-14-3, 1.4436 X3CrNiMo17-12-3, 1.4571 X6CrNiMoTi17-12-2, 1.4580 X6CrNiMoNb17-12-2, 1.4583 X10CrNiMoNb18-12  
 UNS S31600, S31603, S31635, S31640, S31653  
 AISI 316L, 316Ti, 316Cb

## Typical analysis

	C	Si	Mn	Cr	Ni	Mo
wt.-%	0.01	0.45	1.6	18.5	12.2	2.7

## Operating data

Dimension mm	Current A	Voltage V
2.0	250 – 350	28 – 32
2.4	300 – 400	29 – 33
3.2	350 – 500	29 – 33
4.0	425 – 575	30 – 34

## Approvals

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