



CEWELD 316LMn Tig

TYPE Tig filler metal for welding fully austenitic CrNiMnMo stainless steels and low temperature steels.

TOEPASSINGEN Particularly suited for corrosion conditions in urea synthesis plants for welding work on steel X 2 CrNiMo 18 12 and for over-layer claddings of Type 1.4455.. Well suited for joining and cladding applications with matching and similar austenitic CrNi(N) and CrNiMo(Mn,N) steels/cast steel grades.

EIGENSCHAPPEN Stainless steel with excellent resistance to intercrystalline corrosion and wet corrosion up to 350°C (662 °F). Corrosion-resistance is similar to low-carbon CrNiMo(Mn,N) steels/cast steel grades. Seawater resistant, good resistance to nitric acid, selective attack max. 200 µm. Non magnetic (permeability in field of 8000 A/m 1.01 max.).

CLASSIFICATIE

AWS	A 5.9: ER316LMn
EN ISO	14343-A: W 20 16 3 Mn N L
W.Nr.	1.3954 (~1.4455)
F-nr	6
FM	5

GESCHIKT VOOR **ISO 15608: 8.1 Austenitic ≤ 19 % Cr**
 1.3941, 1.3945, 1.3948, 1.3951, 1.3952, 1.3953, 1.3954, 1.3955, 1.3964, 1.3965, 1.4315, 1.4401, 1.4404, 1.4411, 1.4429, 1.4435, 1.4438, 1.4439, 1.4449, 1.4445, 1.4561, 1.4571, 1.6902, 1.6903, 1.6905, 1.5662,
 X5 CrNiMo 17-12-2, X2CrNiMoN 22-15, X2CrNiMoN 18-14-3, X2CrNiMo 18-15, X8 CrMnNi 18-8, X2 CrNiMo 17-13-2, X2 CrNiMo 18-14-3, X2CrNiMoN 17-13-3, X6 CrNiMoTi 17-12-2, X2 CrNiMoN 17-13-5, X3 CrNiMo 18-12-3, X2 CrNiMo 18-15-4, X2 CrNiN 18-10, GX6 CrNi 18-10, GX5 CrNiNb 18-10, X5CrNiN19-9, X1CrNiMoTi18-13-2, 10CrNiTi18-10, (G)X4CrNi18-3, X2CrNiN18-13, X4CrNiMnMoN19-13-8,
 UNS S31600, S31603, S31635, S31700, S31703, S30453
 AISI 316, 316L, 316Ti, 317, 317L, 304LN
 3,5 – 5% Ni-Steel

GOEDKEURINGEN CE

LASPOSITIES

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	P	S	Cr	Ni	Mo	N
0.02	0.55	7.5	0.01	0.01	20	16	3	0.01

MECHANISCHE WAARDEN

Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
				RT		
As Welded	440	620	35	120		HRc

HERDROGEN Not required

GAS ACC. EN ISO 14175 I1



CEWELD 316LMn Tig

316LMN TIG 1,6 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663414984

316LMN TIG 2,0 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663415028

316LMN TIG 2,4 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663415066