

TIGWELD 316L

TIG Rods [GTAW]

Stainless and high alloyed steels

CLASSIFICATION: EN ISO 14343-A : W 19 12 3 L DIN 8556 : SG-X2 CrNiMo19 13 3 L AWS A-5.9 : ER 316L W.Nr. : 1.4430	APPROVALS:	APPLICATION: Power generation industry Petrochemical and chemical industry
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- Rod for welding acid-resistant steel with the addition of Mo.
- The weld is characterized by good resistance to general and intergranular corrosion.
- Can be used in more aggressive environments, e.g. dilute hot acids.
- Good resistance to chloride pitting corrosion.

Application

Construction of wastewater treatment plants, tanks, chemical equipment in the cellulose, chemical and pharmaceutical, food and energy industries.

Base material

EN 10088-1/2 EN 10213-4	W.Nr.	AISI/ASME	PN
X2CrNiMo17 12 2	1.4404	316L CF-3M	OOH17N14M2
X2CrNiMo18 14 3	1.4435	316L	
X2CrNiMoN17 11 2	1.4406	316LN	
X2CrNiMoN17 13 3	1.4429		
X4CrNiMo17 12 2	1.4401	316	OH17N12M2
X4CrNiMo17 13 3	1.4436		
G-X5 CrNiMo19 11	1.4408	CF-8M	
X6 CrNiMoTi17 12 2	1.4471	316Ti	
X6 CrNiMoNb17 12 2	1.4580	316Cb	
X6 CrNiNb18 10	1.4550	347	OH18N12Nb
G-X5 CrNiNb19 10	1.4552	CF-8C	
X10 CrNiMoNb 18 12	1.4583		
G-X2 CrNiMo19 11 2	1.4409		

Typical chemical composition %

C	Si	Mn	Cr	Ni	Mo
<0,02	0,40	1,60	18,50	12,00	2,50

Typical mechanical properties

Yield strength Re [N/mm²]	>420
Tensile strength Rm [N/mm²]	>580
Elongation A5 [%]	>30
Impact energy Kv [J]	>100 J (20°C) /
Ferrite content	FN 9

Welding parameters and packing

∅	Length [mm]	Weight of packet [kg]
1,6	1000 /	5,0

2,0	1000 /	5,0
2,4	1000 /	5,0
3,2	1000 /	5,0

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