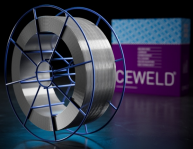




CEWELD 316LMn

TYPE	Solid welding wire for welding fully austenitic CrNiMnMo stainless steels and low temperature steels.(Type 19 12 3Mn, 1.4455)												
APPLICATIONS	Particularly suited for corrosion conditions in urea synthesis plants for welding work on steel X 2 CrNiMo 18 12 and for over-lay 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.												
PROPERTIES	Stainless steel with excellent resistance to intercrystallin 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.).												
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.9: ER316LMn</td> </tr> <tr> <td>EN ISO</td> <td>14343-A: G 20 16 3 Mn N L</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>5</td> </tr> <tr> <td>W.Nr.</td> <td>1.4455</td> </tr> </table>	AWS	A 5.9: ER316LMn	EN ISO	14343-A: G 20 16 3 Mn N L	F-nr	6	FM	5	W.Nr.	1.4455		
AWS	A 5.9: ER316LMn												
EN ISO	14343-A: G 20 16 3 Mn N L												
F-nr	6												
FM	5												
W.Nr.	1.4455												
SUITABLE FOR	<p>ISO 15608: 8.1 Austenitic ≤ 19 % Cr</p> <p>1.3941, 1.3945, 1.3948, 1.3951, 1.3952, 1.3953, 1.3955, 1.3964, 1.3965, 1.4315, 1.4401, 1.4404, 1.4411, 1.4429, 1.4435, 1.4438, 1.4439, 1.4449, 1.4561, 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,</p> <p>UNS S31600, S31603, S31635, S31700, S31703, S30453</p> <p>AISI 316, 316L, 316Ti, 317, 317L, 304LN</p> <p>3,5 – 5% Ni-Steel</p>												
APPROVALS	CE												
WELDING POSITIONS													
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> </tr> </thead> <tbody> <tr> <td>0.015</td> <td>0.5</td> <td>7</td> <td>20</td> <td>17</td> <td>3</td> </tr> </tbody> </table>	C	Si	Mn	Cr	Ni	Mo	0.015	0.5	7	20	17	3
C	Si	Mn	Cr	Ni	Mo								
0.015	0.5	7	20	17	3								
ALL WELD MECHANICAL PROPERTIES	<table border="1"> <thead> <tr> <th>Heat Treatment</th> <th>R_{P0,2} MPa</th> <th>R_m MPa</th> <th>A₅ (%)</th> <th>Impact Energy (J) ISO-V</th> </tr> </thead> <tbody> <tr> <td>As Welded /</td> <td>430</td> <td>650</td> <td>35</td> <td>-196°C 50</td> </tr> </tbody> </table>	Heat Treatment	R _{P0,2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V	As Welded /	430	650	35	-196°C 50		
Heat Treatment	R _{P0,2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V									
As Welded /	430	650	35	-196°C 50									
REDRYING TEMPERATURE	Not required												
GAS ACCORDING EN 14175	M11, M13, M12												



CEWELD 316LMn

316LMN 1,2MM

Type	KG/unit	EANCode
BS-300	15	8720663424587