CEWELD AA 316 LP

certilas® THE FILLER METAL SPECIALIST

TYPE

AISI 316 Rutile flux cored stainless steel welding wire for welding in all positions. (Type 19 12 3L, 1.4430)

APPLICATIONS

CEWELD AA 316LP is suitable for welding AISI 316 stainless steels, especially when high weld metal quality and an attractive weld bead appearance are required.

PROPERTIES

Gentle droplet transfer and stable arc without spatter loss, excellent productivity and weldability, better wetting properties compared to solid wires characterise CEWELD AA 316LP. Faster solidifying rutile slag with which X-ray weld seams are reliably achieved both under CO2 and mixed gas

CLASSIFICATION

AWS	A 5.22: E316LT1-1, A 5.22: E316LT1-4
EN ISO	17633-A: T 19 12 3 L P M21 2
W.Nr.	1.4430
F-nr	6
FM	5

SUITABLE FOR

ISO 15608: 8.1 Austenitic ≤ 19 % Cr , TÜV 1000: Gr. 21-30,
1.4583, 1.4435, 1.4436, 1.4404, 1.4406, 1.4408, 1.4401, 1.4571, 1.4580, 1.4406, 1.4521, 1.4430
X102CrNiMoNb 18 12, X2CrNiMo 18 14 3 (TP), X4CrNiMo 17 13 3, X2CrNiMo 17 12 2 (TP), X 5CrNiMo 19 11 2, X4CrNiMo 17 12 2 (TP), X6CrNiMo 17 12 2, X6CrNiMoNb 17 12 3, X2CrNiMoN 17 12 3 (TP), X2CrMoTi18-2
316Cb, 316L, 316L, 316LN, 316H, 316, 316Ti, 316Cb, 316LN, 444
S31640, S31603, S31653, S31600, S31630, S44400

APPROVALS

CE, Lloyds, DNV

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	Cr	Ni	Mo	S
0.025	0.9	1.4	0.013	17.9	12.1	2.67	0.008

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
				RT	-40°C	
As Welded	380	525	43	65	50	HRc

REDRYING

140°C / 24 hr

GAS ACC. EN ISO 14175

M21

CEWELD AA 316 LP

AA 316 LP 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663413529
D-200	5	8720663413574
D-270	15	8720663424624

AA 316 LP 1MM

Packaging	KG/unit	EanCode
D-200	5	8720682050033