

Standards

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| TS EN ISO 3581-A | : E 19 12 3 L R 32 |
| EN ISO 3581-A | : E 19 12 3 L R 32 |
| AWS A5.4 | : E316L-16 |

**Chemical Composition of
Weld Metal % (Typical)**

| C | Si | Mn | Mo | Ni | Cr |
|------|-----|-----|-----|------|------|
| 0.03 | 0.8 | 0.9 | 2.6 | 11.5 | 19.0 |

Mechanical Properties

| Yield Strength (N/mm ²) | Tensile Strength (N/mm ²) | Impact Strength (ISO-V/+20°C) | Elongation (L ₀ =5d ₀) (%) |
|--|--|----------------------------------|--|
| min. 355 | 540-670 | min. 47 J | min. 30 |

Typical Base Material Grades

- EN: X10CrNiMoNb 18 12, X2CrNiMo 18 14 3, X5CrNiMo 17 13 3, X2CrNiMo 17 13 2, X2CrNiMoN 17 12 2, X5CrNiMo 17 12 2, X5CrNiMoTi 17 12 2, X6CrNiMoNb 17 12 2, X2CrNiMoN 17 13 3.
- AISI: 316Cb, 316, 316L, 316Ti

Features and Applications

- Tanks, pipes and equipments made of Cr-Ni-Mo low-carbon steels which are used in food, textile, chemical and paint industries
- Weld metal is resistant to acid, corrosion
- Serviceability at temperatures up to 400°C
- Requirement of Re-drying for min. 2 hours at the temperatures between 120°C and 200°C

Welding Positions

Current Type

D.C.(+) / A.C.

Operating Data

| Product Code | Diameter x Length (mm) / (inch) | | Welding Current (A) | Weight g / 100 pcs |
|--------------|------------------------------------|------------|------------------------|-----------------------|
| 3010101243 | 2.00 x 250 | 5/64 x 10" | 40-70 | 950 |
| 3010101248 | 2.50 x 250 | 3/32 x 10" | 50-90 | 1500 |
| 3010101258 | 3.20 x 350 | 1/8 x 14" | 80-120 | 3480 |
| 3010101263 | 4.00 x 350 | 5/32 x 14" | 110-160 | 5130 |

Approvals: TSE, BV, CE, ABS, SEPRO, DNV-GL