

## Exaton 16.5.1

16.5.1 is a filler material for joining EN 1.4418 and similar steels. It is also used for overlay welding. The weld metal has excellent resistance to cavitation and is used typically for shafts, propellers, pumps and valves in for example, hydropower generation.

<b>Classifications</b>	EN ISO 14343-A : G 16 5 1
<b>Approvals</b>	CE : EN13479

<b>Alloy Type</b>	Austenitic/Martensitic/Ferritic - 16% Cr - 5% Ni - 1% Mo - Low C
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Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
PWHT 4 hour(s) 590 °C ( 1094 °F )	470 MPa ( 68 ksi )	850 MPa ( 123 ksi )	22 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
PWHT 4 hour(s) 590 °C ( 1094 °F )	20 °C ( 68 °F )	80 J ( 59 ft-lb )

Typical Wire Composition %									
C	Mn	Si	S	P	Ni	Cr	Mo	V	Al
0.01	1.4	0.3	0.009	0.015	5.5	16.2	1.0	0.04	0.006

Typical Wire Composition %				
Cu	N	Nb	Ti	Co
0.01	0.02	0.01	0.01	0.03

Recommended Welding Parameters			
Current	Wire Diameter	Voltage	Wire Feed Speed
150-260 A	1.2 mm ( 0.047 in. )	24-29 V	3.0-10.0 m/min ( 118-394 in./min )