

Classifications

EN ISO 14343-A	AWS A5.9 / SFA-5.9
S 20 16 3 Mn N L	ER316LMn

Characteristics and typical fields of application

Solid wire of G 20 16 3 Mn N L / ER316L (mod.) type for joining and surfacing applications with matching and similar austenitic CrNi(N) and CrNiMo(Mn,N)-steels. Corrosion resistance similar to low-carbon CrNiMo(Mn,N)-steels and cast steel grades. Seawater resistant, good resistance to nitric acid, selective attack max. 200 µm. Non-magnetic (permeability in field of 8000 A/m max. µr 1.01). Particularly suited for corrosion conditions in urea synthesis plants for welding work on steel X2CrNiMo18-12. Resulting all-weld metal microstructure is austenite with max. 0.6% ferrite. Max. service temperature 350°C.

Typical analysis of the solid wire

	C	Si	Mn	Cr	Ni	Mo	N
wt.-%	0.03	0.5	7.5	20.5	15.5	3.0	0.18

Typical fluxes to combine

Process	Name	EN ISO 14174
SAW	Marathon 104	S A FB 2 AC

Packaging

Size(s) in mm
2,4

Other sizes and coil weights on request.

