

Standards

TS EN ISO 3581-A	: E 19 12 3 L B 22
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AWS A5.4	: E 316 L-15

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

C	Si	Mn	Mo	Ni	Cr
0.03	0.45	1.35	2.75	11.5	18.9

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/+20°C)	Elongation (L ₀ =5d ₀) (%)
min. 360	550-700	min. 55 J	min. 35

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

- Low-carbon alloyed-core wire austenitic electrode with basic coating for use in all industries where analogous steels, including higher carbon grades and ferritic 13% Cr types, are welded. High ductility of weld metal, therefore preferably used for welding of heavy sections. Very good out-of-position weldability. Good low-temperature ductility down to -196°C. Resistance to intergranular corrosion up to 400°C.
- No requirement of preheating or postweld heat treatment of weld metal

Welding Positions

Current Type

D.C.(+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010101283	2.50 x 250	3/32 x 10"	60 - 80	1440
3010101288	3.20 x 350	1/8 x 14"	80 - 110	3480
3010101293	4.00 x 350	5/32 x 14"	110 - 140	5080

Approvals: TSE, CE, SEPRO