

**Standards**

TS EN ISO 3581-A	: E Z 19 13 4 L R 12
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AWS A5.4	: E317L-16

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

C	Si	Mn	Mo	Ni	Cr
<0.04	0.8	0.9	3.2	12.5	18.7

**Mechanical Properties**

Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Impact Strength (ISO-V/+20°C)	Elongation (L <sub>0</sub> =5d <sub>0</sub> ) (%)
min. 400	570-700	min. 47 J	min. 30

**Typical Base Material Grades**

- EN: X2CrNiMoN 17 13 3, X2CrNiMoN 17 13 5, X2CrNiMoN 18 18 3, X2CrNiMoN 18 13, X4CrNiMoN 19 16 5, X4CrNiMoN 22 15, X2CrNiMo 18 14 3, X2CrNiMo 18 16 4, X10CrNiMoTi 18 12
- AISI & UNS: 316L, 316Cb, 317, S31726

**Features and Applications**

- Reduces the possibility of intergranular carbide precipitation, providing increase in resistance to intergranular corrosion without use of stabilizers such as Niobium or Titanium
- Rutile-basic coated alloyed-core wire electrode for corrosion-resistant CrNi steels of increased Mo-contents
- 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
3010101318	2.50 x 250	3/32 x 10"	50 - 90	1570
3010101323	3.20 x 350	1/8 x 14"	80 - 120	3470
3010101328	4.00 x 350	5/32 x 14"	110 - 160	5100

**Approvals:** TSE, CE, SEPRO