

Exaton 316/316L

316/316L is used for joining stainless CrNiMo and CrNi steels, stabilized or non-stabilized, e.g. ASTM 316, 316L and 316Ti as well as 304, 304L, 321 and 347, used for service temperatures up to 400°C (750°F). It is also used for Cr steels with max. 19% Cr. It is used for TIG-welding.

Classifications Wire Electrode	SFA/AWS A5.9 : ER316L EN ISO 14343-A : W 19 12 3 L Werkstoffnummer : 1.4430
Approvals	CE EN 13479 DNV-GL VL 316L VdTUV 00066

Approvals are based on factory location. Please contact ESAB for more information.

Alloy Type	Austenitic (with appr. 8 % ferrite) 19 % Cr - 12 % Ni - 3 % Mo - Low C
Shielding Gas	I1 (EN ISO 14175)

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	20 °C (68 °F)	150 J (111 ft-lb)
As Welded	-40 °C (-40 °F)	130 J (96 ft-lb)
As Welded	-196 °C (-321 °F)	75 J (56 ft-lb)

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
<0.02	1.7	0.4	<0.02	<0.03	12	18	2.5	0.1	0.05

Typical Weld Metal Analysis %

Nb	FN WRC-92
0.01	7

Typical Wire Composition %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
0.015	1.7	0.4	0.015	<0.025	12	18.5	2.6	0.1	0.04

Typical Wire Composition %

Nb	FN WRC-92
0.02	9