

Exaton 19.12.3.L

19.12.3.L is used for welding of austenitic stainless alloys of 18% Cr - 8% Ni and 18% Cr - 10% Ni - 3% Mo-types, 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 MIG/MAG welding.

Classifications Wire Electrode	SFA/AWS A5.9 : ER316L EN ISO 14343-A : G 19 12 3 L Werkstoffnummer : 1.4430
Approvals	CE EN 13479

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	M12, M13 (EN ISO 14175)

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	20 °C	150 J
As Welded	-40 °C	130 J
As Welded	-196 °C	75 J

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

Recommended Welding Parameters

Wire Diameter	Current	Voltage	Wire Feed Speed
0.8 mm	40-120 A	15-19 V	4.0-8.0 m/min
1.0 mm	60-220 A	15-28 V	4.0-12.0 m/min
1.2 mm	150-260 A	24-29 V	3.0-10.0 m/min
1.6 mm	230-350 A	25-30 V	3.0-5.0 m/min