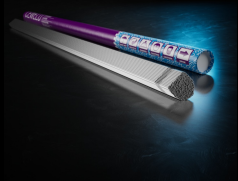




# CEWELD 316LSi Tig

|                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                         |                      |                    |                         |        |          |     |
|---------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------|----------------------|--------------------|-------------------------|--------|----------|-----|
| TYPE                                              | Stainless steel Tig welding wire (rod) for GTAW welding CrNiMo 316 steels. ( Type 1.4430, 19 12 3 LSi)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                         |                      |                    |                         |        |          |     |
| APPLICATIONS                                      | The alloy is widely used in the chemical and food-processing industries, as well as in shipbuilding and various types of architectural structure.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                         |                      |                    |                         |        |          |     |
| PROPERTIES                                        | CEWELD® 316LSi Tig offers good general corrosion resistance, particularly to corrosion in acid and chlorinated environments. The alloy has a low carbon content which makes it particularly recommended when there is a risk of intergranular corrosion. The higher silicon content improves the welding properties such as wetting and results in a bright seam.                                                                                                                                                                                                                                                                           |                         |                      |                    |                         |        |          |     |
| CLASSIFICATION                                    | AWS                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | A 5.9: ER316LSi         |                      |                    |                         |        |          |     |
|                                                   | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | 14343-A: W 19 12 3 LSi  |                      |                    |                         |        |          |     |
|                                                   | W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | 1.4430                  |                      |                    |                         |        |          |     |
|                                                   | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | 6                       |                      |                    |                         |        |          |     |
|                                                   | FM                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | 5                       |                      |                    |                         |        |          |     |
| SUITABLE FOR                                      | ISO 15608: 8.1 Austenitic ≤ 19 % Cr , TÜV 1000: Gr. 21-30,<br>1.4583, 1.4435, 1.4436, 1.4404, 1.4406, 1.4408, 1.4401, 1.4571, 1.4580, 1.4406, 1.4521, 1.4301, 1.4306, 1.4430<br>X102CrNiMoNb 18 12, X2CrNiMo 18 14 3 (TP), X4CrNiMo 17 13 3, X2CrNiMo 17 12 2 (TP), X 5CrNiMo 19 11 2, X4CrNiMo 17 12 2 (TP), X6CrNiMo 17 12 2, X6CrNiMoNb 17 12 3, X2CrNiMoN 17 12 3 (TP), X2CrMoTi18-2<br>316Cb, 316L, 316L, 316LN, 316H, 316, 316Ti, 316Cb, 316LN, 444<br>S31640, S31603, S31653, S31600, S31630, S44400                                                                                                                                 |                         |                      |                    |                         |        |          |     |
| APPROVALS                                         | TÜV: (12389), CE, DB: (43.206.04)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                         |                      |                    |                         |        |          |     |
| WELDING POSITIONS                                 | <div> PA  PB  PC  PD  PE  PF  PG</div> |                         |                      |                    |                         |        |          |     |
| TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | Si                      | Mn                   | P                  | S                       | Cr     | Ni       | Mo  |
|                                                   | 0.02                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | 0.8                     | 1.8                  | 0.01               | 0.01                    | 19     | 12       | 2.8 |
| MECHANICAL PROPERTIES                             | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | R <sub>P0.2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V |        | Hardness |     |
|                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                         |                      |                    | RT                      | -196°C |          |     |
|                                                   | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | 450                     | 580                  | 37                 | 120                     | 52     | HRc      |     |
| REDRYING                                          | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                         |                      |                    |                         |        |          |     |
| GAS ACC. EN ISO 14175                             | I1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                         |                      |                    |                         |        |          |     |



# CEWELD 316LSi Tig

|                         |           |         |               |
|-------------------------|-----------|---------|---------------|
| 316LSI TIG 0,8 X 1000MM | Packaging | KG/unit | EanCode       |
|                         | Tube      | 5       | 8720663414854 |
| 316LSI TIG 1,0 X 1000MM | Packaging | KG/unit | EanCode       |
|                         | Tube      | 5       | 8720663414892 |
|                         | Tube      | 5       | 8720663414861 |
| 316LSI TIG 1,2 X 1000MM | Packaging | KG/unit | EanCode       |
|                         | Tube      | 5       | 8720663414939 |
|                         | Tube      | 5       | 8720663414908 |
| 316LSI TIG 1,6 X 1000MM | Packaging | KG/unit | EanCode       |
|                         | Tube      | 5       | 8720663414946 |
| 316LSI TIG 1,6 X 500MM  | Packaging | KG/unit | EanCode       |
|                         | Tube      | 5       | 8720663414960 |
| 316LSI TIG 2,0 X 1000MM | Packaging | KG/unit | EanCode       |
|                         | Tube      | 5       | 8720663414991 |
| 316LSI TIG 2,4 X 1000MM | Packaging | KG/unit | EanCode       |
|                         | Tube      | 5       | 8720663415035 |
| 316LSI TIG 3,2 X 1000MM | Packaging | KG/unit | EanCode       |
|                         | Tube      | 5       | 8720663415073 |
| 316LSI TIG 4,0 X 1000MM | Packaging | KG/unit | EanCode       |
|                         | Tube      | 5       | 8720663415097 |