316L-LF

AWS A 5.9: ER316L ISO 14343-A: 19 12 3 L
W.N 1.4430

DESCRIPTION

Low carbon austenitic stainless alloy with a controlled lower ferrite level <5. This provides a toughness in very low temperatures. Used for welding, repairing and overlaying of stainless steel grades like 316L when weld metal ferrite needs to be low, applications involving cryogenic industry to obtain low impact toughness and high strength.

WELDING POSITIONS	CURRENT	GAS
	Mig, DC+ Tig, DC-	Mig, Ar/Co2(M12) Tig, Ar(I1)

BASE MATERIALS

316, 316L, 304

MECHANICAL PROPERTIES

Rm (Mpa)	*Rp 0,2 (Mpa)*	*A5 (%)*	*Charpy-V Impact(R.T.)*
>510	>320	>25	>80J

WELD METAL COMPOSITION(%)

C	Mn	Si	Cr	Mo	Ni	S	P	Cu	FN
<0,03	1,0-2,5	0,3-0,65	18-20	2,5-3,0	11-14	<0,02	<0,03	<0,5	<5

PACKAGING

Mig Dimension(mm)	0,8	1,0	1,2	
Spool size(kg)	15	15	15	
Tig Dimension(mm)	1,6x1000	2,0x1000	2,4x1000	3,2x1000
Box size(kg)	5	5	5	5