

# INERTFIL 316 L Si

Drôt pre zváranie MAG/TIG

Welding rod/wire electrode for TIG/MAG-welding process

Pręty/druty do spawania metodami TIG/MAG



## Standards:

DIN EN 12072

DIN 8556

AWS/ASME SFA-5.9

Comparable No. of Materials:

G 19 12 3 L Si

SG X 2 Cr Ni Mo 19 12

ER 316 L Si

1.4430

## SK Vlastnosti a použitie:

Austenitický zvärací drôt v L kvalite (veľmi nízky obsah uhlíka) pre zváranie nestabilizovaných a stabilizovaných nehrdzavejúcich CrNiMo ocelí metódou TIG a MAG. Odolný proti medzikryštalickej korózii pri prevádzkových teplotách do 400 °C.

## GB Applications and properties:

Austenitic stainless welding rod or wire electrode in ELC-quality for TIG/MAG-welding of unstabilized and stabilized, corrosion resisting Cr Ni Mo-steels. Resistant to intergranular corrosion up to 400 °C.

## POL Zastosowania i własności:

Pręt do spawania lub druty z austenitycznej stali nierdzewnej klasy ELC do spawania stabilizowanych lub niestabilizowanych stali nierdzewnych Cr-Ni-Mo metodą TIG/ MAG. Stopiwo odporne na korozję międzykryształiczną do 400°C.

## Materials for instance:

No. of Materials	EN-Designation	No. of Materials	EN-Designation
1.4401	XCrNiMo17-12-2	1.4571	X 6CrNiMoTi17-12-2

## Approvals:

TÜV, TÜV Austria, DB

## Rod and wire analysis correspond to all-weld metal analysis (typical values in %)

C	Si	Mn	Cr	Ni	Mo	P	S
0,02	0,85	1,40	19,00	12,50	2,60	≤0,025	≤0,020

## Mechanical properties of all-weld metal (single values are typical values):

Heat treatment	0,2 % Proof stress [N/mm <sup>2</sup> ]	Tensile strength [N/mm <sup>2</sup> ]	Elongation A <sub>5</sub> [%]	Impact energy ISO-V [J]
				+20 °C
AW	≥350	≥510	≥30	≥47

AW = as-welded

Analysis and mechanical properties apply to the use of shielding gas:

DIN EN 439 - I1 in TIG – welding

DIN EN 439 - M13 in MAG – welding

## Shielding gas acc. to DIN EN 439:

Welding rod for TIG-welding:

I1 (ARCAL 1)

Wire electrode for MAG -welding:

M12 (ARCAL 12), M13 (INARC S 3)

Consumption:

TIG = approx. 10 l/min, MAG = approx. 15 l/min

## Form of delivery:

Welding rods						
Dia. [mm]	1,0	1,6	2,0	2,4	3,2	4,0
Length [mm]	1000					
Approx. Weight of packet [kgs]	10					

Wire electrodes						
Dia [mm]	0,6	0,8	1,0	1,2	1,6	
Wire cage reel K300 [kgs]	15					

Further forms of delivery on request.

## Type of current/Polarity/Welding positions:

