Exaton 16.5.1 (GMAW)

16.5.1 is a filler material for joining EN 1.4418 and similar steels. It is also used for overlay welding. The weld metal has excellent resistance to cavitation and is used typically for shafts, propellers, pumps and valves in for example, hydropower generation.

Specifications	
Classifications	EN ISO 14343-A : G 16 5 1
Approvals	CE : EN13479

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

Alloy Type	Austenitic/Martensitic/Ferritic - 16% Cr - 5% Ni - 1% Mo - Low C
Shielding Gas	I3 (EN ISO 14175)

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
PWHT 4 hour(s) 590 °C (1094 °F)	470 MPa (68 ksi)	850 MPa (123 ksi)	22 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
PWHT	20 °C (68 °F)	80 J (59 ft-lb)

Typical Wire Composition %									
C	**Mn**	**Si**	**S**	**P**	**Ni**	**Cr**	**Mo**	**V**	**Al**
0.01	1.4	0.3	0.009	0.015	5.5	16.2	1.0	0.04	0.006

Typical Wire Composition %				
Cu	**N**	**Nb**	**Ti**	**Co**
0.01	0.02	0.01	0.01	0.03

Recommended Welding Parameters			
Current	**Wire Diameter**	**Voltage**	**Wire Feed Speed**
150-260 A	1.2 mm (0.047 in.)	24-29 V	3.0-10.0 mm/min (118-394 in./min)