Exaton 19.12.3.L

Exaton 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 Submerged Arc Welding in combination with Exaton Flux 15W or Exaton Flux 10SW.

Specifications	
Classifications	EN ISO 14343-A : S 19 12 3 L SFA/AWS A5.9 : ER316L Werkstoffnummer : ~1.4430
Approvals	CE : EN 13479 UKCA : EN 13479 VdTÜV : 03771

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

Typical Wire Composition %

C	Mn	Si	S	P	Ni	Cr	Mo	N
<0.020	1.8	0.4	<0.015	<0.025	12.5	18.5	2.6	<0.060