

Exaton 19.12.3.LR

Exaton 19.12.3.LR is a chromium-nickel-molybdenum covered electrode with rutile coating for welding of low carbon, molybdenum alloyed, austenitic stainless steels of 316L (1.4436) type. Exaton 19.12.3.LR is used for welding steel of the types ISO: 1.4401, 1.4404, 1.4435, 1.4436, 1.4571 and ASTM: 316, 316L, 316LN, 316H and 316Ti. In cases where creep strength is of secondary importance, Exaton 19.12.3.LR is suitable for welding of corresponding stabilized austenitic steels. When a weld metal similar to the parent metal is not required, Exaton 19.12.3.LR can be used for welding ferritic and martensitic steels.

Specifications

Classifications	EN ISO 3581-A : E 19 12 3 L R 1 2 SFA/AWS A5.4 : E316L-17 CSA W48 : E316L-17 Werkstoffnummer : 1.4430
Approvals	CE : EN 13479 CWB : E316L-17 UKCA : EN 13479 VdTÜV : 07789

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

Welding Current	DC+, AC
Ferrite Content	FN 3-10
Alloy Type	Austenitic CrNiMo
Coating Type	Acid Rutile

Tensile Properties

Testing Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	470 MPa	590 MPa	35 %

Charpy Testing

Testing Condition	Testing Temp	Impact Value
ISO		
As Welded	-105 °C	36 J
As Welded	-20 °C	60 J
As Welded	20 °C	70 J

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
0.02	0.8	1	0.015	0.024	12	18.5	2.8	0.07	0.10

Typical Weld Metal Analysis %

FN deLong	FN WRC-92	Ferrite % Schaeffler
7	3	7

Deposition Data

Diameter	Amps	Volts	Efficiency (Per)	Fusion time per electrode at 90Per I max	Deposition rate at 90Per
2.5 x 300.0 mm	45-90 A	29 V	55 %	45 sec	0.9 kg/h
3.2 x 350.0 mm	60-125 A	30 V	55 %	57 sec	1.4 kg/h
4.0 x 350.0 mm	70-190 A	32 V	56 %	57 sec	2.0 kg/h