

Classifications

EN ISO 14343-A	EN ISO 14343-B	ASME II C SFA 5.9
B 21 13 3 L	BS309LMoD	(EQ309LMo)

Characteristics and typical fields of application

- SOUDOTAPE 21.13.3L is an overall alloyed low carbon austenitic stainless steel strip electrode to produce single layer weld overlay of corrosion resistant stainless steel 316L (1.4404). For improved corrosion resistance, a second layer with SOUDOTAPE 316L is optional.

- SOUDOTAPE 21.13.3L is suitable as buffer layer.

- In combination with single layer electroslag flux RECORD EST 316-1, the highest productivity shall be get.

SOUDOTAPE 21.13.3L is suitable for 3.5% molybdenum austenitic stainless steel 317L weld overlay. 317L with its higher chromium and molybdenum content is more resistant to intergranular attack and pitting corrosion than 316L.

- Used in combination with RECORD EST 122Mo or RECORD EST317-1, to produce single layer austenitic stainless steel weld overlay that meet requirement of designation 317L (1.4438).

- Used in combination with RECORD EST 136Mo, high productivity two layer weld overlay that meet requirement of designation 317L (1.4438).

- SOUDOTAPE 21.13.3L is suitable for niobium stabilised austenitic stainless steel 318 weld overlay. Niobium enhance resistance to intergranular corrosion in comparison with 316L.

- Used in combination with RECORD EST 130, to produce single layer niobium stabilised austenitic stainless steel weld overlay that meet requirement of designation 318 (~1.4576).

- SOUDOTAPE 21.13.3L is used in a wide variety of industries such as chemical and petrochemical where resistance to localised corrosion is of concern.

TUV approval 09411.05 available with RECORD EST 122

Typical analysis

	C	Si	Mn	Cr	Ni	Mo	N	Fe
wt.-%	0.01	0.3	1.7	20.6	13.9	2.9	0.04	Rem.

Typical fluxes to combine

Process	Name	EN ISO 14174
ESW	RECORD EST 122	ES A FB 2B
ESW	RECORD EST 122Mo	ES A FB 2B
ESW	RECORD EST 130	ES A FB 2B
ESW	RECORD EST 136	ES A FB 2B
ESW	RECORD EST 136Mo	ES A FB 2B
ESW	RECORD EST 316-1	ES A FB 2B
ESW	RECORD EST 317-1	ES A FB 2B
ESW	RECORD EST 501	ES A FB 2B
SAW	RECORD INT 101	S A AB 2B

Packaging

Size(s) in mm	Type	Weight
30 x 0,5	Coil	25 - 30 kg
60 x 0,5	Coil	50 - 60 kg
90 x 0,5	Coil	75 - 90 kg

Other sizes and coil weights on request.