

## Classifications

<b>EN ISO 14343-A</b>	<b>AWS A5.9 / SFA-5.9</b>	<b>EN ISO 14174</b>
S 19 12 3 L	ER316L	S A AF 2 DC

## Characteristics and typical fields of application

**Thermanit GE-316L - Marathon 805** is a wire-flux-combination for welding of stainless steel grades such as 1.4435 / 316L. Solid SAW wire of S 19 12 3 L / ER316L type for joining and surfacing application with matching and similar unstabilized austenitic CrNi(N) and CrNiMo(N)-steels and cast steel grades. Corrosion resistance similar to matching low-carbon and stabilized austenitic CrNiMo-steels. Max. service temperature 400°C. Low temperature service down to -196°C. The former product name of the SAW wire was "Avesta 316L/SKR".

**Marathon 805** is an agglomerated basic flux that ensures good welding properties with nice bead appearance and good slag detachability. The flux avoids excessive Cr-burn-out (Cr-support). For more information regarding this sub-arc welding flux, see the separate datasheet. The former product name of the SAW flux was "Avesta Flux 805".

## Base materials

1.4401 X5CrNiMo17-12-2, 1.4404 X2CrNiMo17-12-2, 1.4409 GX2CrNiMo19-11-2, 1.4429 X2CrNiMo17-12-3, 1.4432 X2CrNiMo17-12-3, 1.4435 X2CrNiMo18-14-3, 1.4436 X3CrNiMo17-12-3, 1.4571 X6CrNiMoTi17-12-2, 1.4580 X6CrNiMoNb17-12-2, 1.4583 X10CrNiMoNb18-12  
UNS S31600, S31603, S31635, S31640, S31653  
AISI 316L, 316Ti, 316Cb

## Typical analysis


wt.-%	C	Si	Mn	Cr	Ni	Mo
wire	0.01	0.45	1.6	18.5	12.2	2.7
all-weld metal	0.01	0.60	1.2	19	12.2	2.7

## Mechanical properties of all-weld metal - typical values (min. values)

Condition	Yield strength R <sub>p0.2</sub>	Tensile strength R <sub>m</sub>	Elongation A (L <sub>0</sub> =5d <sub>0</sub> )	Impact energy ISO-V KV J	
	MPa	MPa	%	20°C	-196°C
u	430 (≥ 350)	570 (≥ 550)	36 (≥ 30)	80 (≥ 60)	35

u untreated, as-welded

## Operating data

	Dimension mm	Current A	Voltage V
	2.0	250 – 350	28 – 32
	2.4	300 – 400	29 – 33
	3.2	350 – 500	29 – 33
	4.0	425 – 575	30 – 34

No preheating. Suggested heat input is max. 2.0 kJ/mm and interpass temperature max. 150°C. Polarity DC+.

Post-weld heat treatment generally not needed. In special cases, solution annealing can be performed at 1050°C followed by water quenching.

## Approvals

TÜV (06036), DNV GL