

EN 1600: E Z 18 16 4 L R 3 2

BÖHLER FOX CN 18/16 M-A

**Stick electrode,
high alloyed, highly corrosion resistant**

Characteristics and application

Rutile-basic coated low-carbon electrode for joint welding of stable **austenitic CrNiMo steels featuring elevated resistance to weld decay** and for the deposition of top layers of analogous claddings on sheets and plates.

Used in the **chemical industry** for components exposed to **severe chemical attack**. Fully austenitic weld metal, soft welding characteristics, **easy slag removal, good weld purity, and excellent weldability on AC**.

Preheating and postweld heat treatment not required. Max. interpass temperature 150°C. Heat input should be minimized. Root pass welding should preferably be done by the TIG process, using ASN 5-IG welding wire.

Typical chemical composition of all-weld metal

	C	Si	Mn	Cr	Ni	Mo	N	PRE _N
wt-%	≤ 0,03	0.7	0.7	17.8	16.0	3.8	0.15	32.7

Mechanical properties of all-weld metal

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Yield strength R _e N/mm ² :	450	(≥345)
Tensile strength R _m N/mm ² :	620	(580-690)
Elongation A (L ₀ =5d ₀) %:	34	(≥25)
Impact strength ISO-V A _v J +20°C:	75	(≥47)

(*) u untreated, as welded

Welding instruction



Rebaking: **250-300°C, min. 2 h**

Electrode identification:

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ø mm	L mm	Amp.
2.5	350	60-90
3.2	350	90-120
4.0	350	120-150
5.0	450	150-180



Base materials

1.4435 X2CrNiMo18-14-3, 316 L

1.4429 X2CrNiMoN17-11-2

Approvals

TÜV-D, BN, CEPROS