

Low temperature steels																					
Type / code	Filler metal	Base metal	covered electrodes					wires and rods													
						1.4316	1.4430	2.4648	2.4621	1.4316	1.4316	1.4351	1.4351	1.4430	1.4430	2.4806	2.4806	2.4831	2.4831		
			E 42 4 B 42 H5	E 46 4 B 32 H5	E 69 4 Mn2NiCrMo B T 42 H5	E 199 L R 12	E 19 12 3 L R 23	EL-NiCr 19 Nb	EL-NiCr 20 Mo 9 Nb		G 199 L Si	W 199 L Si	G 19 9 Nb Si	W 19 9 Nb Si	G 19 12 3 L Si	W 19 12 3 L Si	SG-NiCr 20 Nb	SG-NiCr 20 Nb	SG-NiCr 21 Mo 9 Nb	SG-NiCr 21 Mo 9 Nb	
The lowest use temperature in °C			- 40	- 40	- 40	- 120	- 120	- 196	- 196		- 196	- 169	- 100	- 120	- 120	- 120	- 196	- 269	- 196	- 196	
Fine grain making steels for low temperatures in accordance to DIN EN 10028-3 (DIN 17102)																					
1.1103	S255NL1 (EStE255)	- 60	●																		
1.1104	P275NL2 (EStE285)	- 60	●																		
1.1105	S315NL1 (EStE315)	- 60	●																		
1.1106	P355NL2 (EStE355)	- 60	●																		
1.8911	S380NL1 (EStE380)	- 60	●																		
1.8913	S420NL1 (EStE420)	- 60	●																		
1.8915	P460NL1 / TStE460	- 50		●																	
1.8917	S500NL / TStE500	- 50			●																
Cold tough steels in accordance to DIN 17174, DIN 17280 and DIN EN 10028-4																					
1.6212	11MnNi5-3	- 60							○									○	○		
1.6217	13MnNi6-3	- 60							○									○	○		
1.6228	15 NiMn 6	- 80							○									○	○		
1.5637	12Ni14	- 100							●									●	●		
1.5680	12Ni19	- 120							●									●	●		
1.6349	X7NiMo6	- 160							○									○	○		
1.5662	X8Ni9	- 196							○									○	○	○	○
Stainless steels in accordance to DIN EN 10088-1/-2																					
1.4301	X5CrNi18-10	- 196			●	□	●	●		●	●			□	□	●	●	●	●	●	●
1.4303	X4CrNi18-12	- 196			●	□	●	●		●	●			□	□	●	●	●	●	●	●
1.4306	X2CrNi19-11	- 196			●	□	●	●		●	●			□	□	●	●	●	●	●	●
1.4541	X6CrNiTi18-10	- 196			●	□	●	●		●	●	●	●	□	□	●	●	●	●	●	●
1.5550	X6CrNiNb18-10	- 196			●	□	●	●		●	●	●	●	□	□	●	●	●	●	●	●
1.4401	X5CrNiMo17-12-2	- 60				●	●	●						●	●	●	●	●	●	●	●
1.4404	X2CrNiMo17-12-2	- 60				●	●	●						●	●	●	●	●	●	●	●
1.4571	X6CrNiMoTi17-12-2	- 60				●	●	●						●	●	●	●	●	●	●	●
1.4580	G-X 10 CrNiMoNb 18 10	- 60				●	●	●						●	●	●	●	●	●	●	●
1.4311	X2CrNi18-10	- 253			●	□	●	●		●	●			□	□	●	●	●	●	●	●
1.4406	X2CrNiMoN17-11-2	- 253			●	●	●	●						●	●	●	●	●	●	●	●
1.4429	X2CrNiMoN17-13-3	- 253			●	●	●	●						●	●	●	●	●	●	●	●

- = suitable filler metal, take into account to the lowest working temperature
- = fairly suitable, if request please repuest range of application
- = suitable, (with the exception of oxidizing media, e.g. nitric acid.)