

CLASSIFICATIONS

EN ISO 14343-A : G Z 19 12 3 L Si

AWS A5.9 : ER 316 LSi

DESCRIPTION

- MIG welding of 13% ferritic stainless steels, high-carbon or stabilized stainless steels of type 316 and low carbon stainless steels of type 316 L, used in machinery and equipment parts of production plants for food, chemical, drug, textile and similar kinds of industries
- As shielding gas, Ar+ %2.5 O₂ or Ar+ %2.5 CO₂ mixed gas is used
- Maintenance of resistance to intergranular corrosion at temperature values up to 400°C.
- Resistance to low temperatures varying at values down to -196°C

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL)

C: 0.02 | Si: 0.80 | Mn: 1.6 | Cr: 18.5 | Ni: 11.5 | Mo: 2.2

MECHANICAL PROPERTIES

| Yield Strength (MPa) | Tensile Strength (MPa) | Impact Strength (ISO-V/+20°C) | Elongation (L ₀ =5d ₀) (%) |
|-------------------------|---------------------------|----------------------------------|--|
| min. 400 | 550 - 700 | min. 63 J | min. 30 |

BASE MATERIALS

- X2 CrNiMo 1814 3, X5 CrNiMo 1713 3, X2 CrNiMo 1713 2, X5 CrNiMo 1712 2, X6 CrNiMoTi 1712 2, X6 CrNiMoNb 1712 2, X2 CrNiMoNb 1713 3, X2 CrNiMoNb 1712 2
- AISI: 316, 316Cb, 316L, 316Ti

WELDING POSITIONS



CURRENT CONDITION

MIG D.C.(+)

OPERATING DATA

| Product Code | Diameter x Length (mm) / (inch) | | Weight (Kg) | Package Type |
|--------------|------------------------------------|--------|----------------|--------------|
| | mm | inch | | |
| 1011100052 | 0,8 | 0.030" | 12.5 | BS 300 |
| 1011100053 | 1 | 0.040" | 15 | BS 300 |
| 1011100054 | 1,2 | 0.047" | 15 | BS 300 |
| 1011100055 | 1,6 | 0.062" | 15 | BS 300 |