

## ER316L

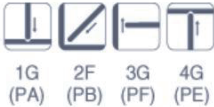
AWS A5.9 ER316L

EN ISO 14343-A : W 19 12 3 L

### Description:

A super low carbon and high silicon stainless steel welding wire has high deposition efficiency, used to weld 19%Cr12%Ni2%Mo and similar stainless steels. The low carbon content to help prevent intergranular corrosion and higher silicon increase weld puddle fluidity, suitable for high speed welding. Used to weld 19%Cr13%Ni2%Mo and similar stainless steels, like food and Beverage, Petrochemical plants, Pulp and Paper, other general fabrication on stainless steels.

### Welding Position:



### Diameters:

0.8mm,0.9mm,1.0mm,1.2mm.

### Typical Mechanical Properties:

Tensile strength(MPa):	530
Yield strength(MPa):	410
Elongation(%):	42

### Typical Chemical Compositon:

C	Mn	P	S	Si	Ni	Cr	Mo	Cu
0.02	1.9	0.012	0.008	0.85	13.0	19.0	2.6	0.015

### Welding Current:(DC+)

Diameter(mm)	0,8	0,9	1,0	1,2
Current/A	55-160	65-220	80-240	100-300
Voltage/V	15-24	15-28	15-28	15-29

### Note:

- 1.Rusty, oil stains, water and other impurity on the weld parts must be cleaned before welding.
- 2.Shield Gas:Ar+0,5-5%CO<sub>2</sub> or Ar+0,5-3%O<sub>2</sub>.
- 3.Gas speed:20-25L/Min
- 4.DC+ connection; Arc length:4-6mm.

**5. Tig rods ER316L 1.6mm, 2.0mm, 2.4mm, 3.2mm available**