CrInoxTIG 316LSi

Solid wire Gas
Tungsten Arc Solid

Classifications EN ISO 14343-A W 19 12 3 L Si
AWS A5.9 ER316LSi

CrInoxTIG 316LSi is primarily intended for welding the low carbon, molybdenum alloyed, acid resisting 316L austenitic stainless steels of similar composition. It is also suitable for grade 316 material and the Nb or Ti stabilised grades 347 and 321, provided service temperatures for structural work are below 350 °C. The higher silicon content provides a more fluid weld pool which may be preferred for certain welding applications.

Shielding Gas I1, Ar 99.99%, 6-12 l/min **Welding Current** DC-

Scaling temperature

Corrosion resistance Good resistance to general and intergranular corrosion in the more severe environments e.g. hot dilute acids. Good resistance to chloride pitting corrosion.

Weld metal chemistry %

FN > 6

Notes :

	%C	%Si	%Mn	%P	%S	%Cr	%Ni	%Mo	%Cu
Min		0,65	1,0			18,0	11,0	2,5	
Typical	0,022	0,85	1,82	0,025	0,005	18,3	11,3	2,6	0,1
Max	0,030	1,0	2,5	0,03	0,02	20,0	14,0	3,0	0,50

Mechanical properties Welding Conditions : As Welded

Typical values		
Yield Strength, Re	400	MPa
Tensile Strength, Rm	585	MPa
Elongation A5	40	%

	T °C	Typical (J)
Impact energy, CV	20	110
	-196	40

Minimum values		
Yield Strength, Re	320	MPa
Tensile Strength, Rm	510	MPa
Elongation A5	30	%

CE	TÜV	DB	LR	DNV	BV	ABS	RINA	RMS	NAKS
X	X (1,6 - 3,2mm)	X (1,6 - 3,2mm) Pending		X					

Available diameters : 1,0 - 3,2mm