

CATEGORY GMAW-GTAW Solid wires

TYPE Stainless steel Mig/Mag wire for GMAW welding 316 types

APPLICATIONS The alloy is widely used in the chemical and food-processing industries, as well as in shipbuilding and various types of architectural structure.

PROPERTIES CEWELD® 316LSi offers good general corrosion resistance, particularly to corrosion in acid and chlorinated environments. The alloy has a low carbon content which makes it particularly recommended when there is a risk of intergranular corrosion. The higher silicon content improves the welding properties such as wetting and results in a bright seam.

CLASSIFICATION	AWS	A 5.9: ER316LSi
	EN ISO	14343-A: G 19 12 3 LSi
	F-nr	6
	FM	5
	W.Nr.	1.4430

SUITABLE FOR	1.4583	X102CrNiMoNb 18 12	316Cb	UNS S31640
	1.4435	X2CrNiMo 18 14 3 (TP)	316L	.
	1.4436	X4CrNiMo 17 13 3	-	.
	1.4404	X2CrNiMo 17 12 2 (TP)	316L	UNS S31603
	1.4406	-	316LN	UNS S31653
	1.4408	X 5 CrNiMo 19 11 2	316H	.
	1.4401	X4CrNiMo 17 12 2 (TP)	316	UNS S31600
	1.4571	X6CrNiMo 17 12 2	316 Ti	UNS S31635
	1.4580	X6CrNiMoNb 17 12 3	316Cb	.
	1.4406	X2CrNiMoN 17 12 3 (TP)	316LN	.

APPROVALS TÜV (12388.00) CE DB (43.206.04)

WELDING POSITIONS:



TYPICAL WELD DEPOSIT WEIGHT %

C	Si	Mn	Cr	Ni	Mo
0.02	0.8	1.5	19	12	2.8

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{p0.2} MPa	R _m MPa	A ₅ (%)	RT	Impact Energy (J) ISO-V -196°C
As Welded /	410	620	37	120	55

WELDING PARAMETERS / PACKING

WELDING PARAMETERS	WELDING PARAMETERS	WELDING PARAMETERS	PACKING	PACKING	PACKING
D (MM)	VOLTAGE (V)	CURRENT (A) DC+	SPOOL TYPE	KG / SPOOL	KG / PALLET
0.6	-	-	D-200 / D-300	5 / 15	1000 / 1080
0.8	12-24	55-160	D-200 / K-300 / DRUM	5 / 15 / 250	1000 / 1080 / 1000
1.0	15-28	80-240	D-200 / K-300 / DRUM	5 / 15 / 250	1000 / 1080 / 1000
1.2	15-29	100-300	D-200 / K-300 / DRUM	5 / 15 / 250	1000 / 1080 / 1000
1.6	23-31	150-375	D-200 / K-300 / DRUM	5 / 15 / 250	1000 / 1080 / 1000

REDRYING TEMPERATURE Not required

GAS ACCORDING EN 14175 M11, M13, M12