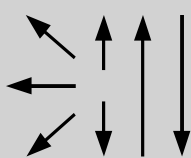


Classifications						
EN ISO 14343-A		EN ISO 14343-B		AWS A5.9		
G 19 12 3 L Si		SS316LSi		ER316LSi		
Characteristics and typical fields of application						
GMAW solid wire designed for first class welding, good wetting and feeding characteristics as well as reliable corrosion resistance up to +400 °C.						
Low temperature service down to –196 °C.						
Base materials						
1.4401 X5CrNiMo17-12-2, 1.4404 X2CrNiMo17-12-2, 1.4435 X2CrNiMo18-14-3, 1.4436 X3CrNiMo17-13-3, 1.4571 X6CrNiMoTi17-12-2, 1.4580 X6CrNiMoNb17-12-2, 1.4583 X10CrNiMoNb18-12, 1.4409 GX2CrNiMo19-11-2						
UNS S31603, S31653; AISI 316L, 316Ti, 316Cb						
Typical analysis of solid wire						
	C	Si	Mn	Cr	Ni	Mo
wt.-%	0.02	0.8	1.7	18.4	12.4	2.8
Mechanical properties of all-weld metal						
Condition	Yield strength R _{p0,2}	Tensile strength R _m	Elongation (L ₀ =5d ₀)	Impact work ISO-V KV J		
	MPa	MPa	%	+20 °C	–196 °C	
u	420 (≥ 320)	560 (≥ 510)	35 (≥ 25)	70	≥ 32	
u untreated, as welded – shielding gas Ar + 2.5 % CO ₂						
Operating data						
	Polarity: DC (+)	Shielding gases: Argon + max. 2.5 % CO ₂	ø (mm) BS300, S300			
			0.8			
			0.9			
			1.0			
			1.2			
			1,6			
Approvals						
TÜV (12937.), DB (43.132.39), CE						