



MIG 20/10MN

Old reference: MIG 316MnN

Classification

ISO14343-A : G 20 16 3 Mn N L Material N° : 1.4455
 AWS A5.9 : ER316LMn

Description & Applications

Solid stainless steel GMAW wire, fully austenitic, for joining of high strength stainless steels used for cryogenic applications.

Base materials

Stainless steels for general use:

UNS	Alloy	EN 10088	Mat. N°	UGINE
S31603	316L	X2CrNiMo17-12- 2	1.4404	UGINOX 18-11 ML
S31651	316N	X2CrNiMoN17-11-2	1.4406	
S31653	316LN	X2CrNiMoN17-13-3	1.4429	
S31600	316	X3CrNiMo17-13-3	1.4436	
S31753	317LN	X2CrNiMoN18-15-4	1.4442	

Typical Chemical Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	N	P	S	Fe
0.02	0.5	7.0	20.0	16.0	3.0	0.1	0.15	<0.02	<0.01	Rem.

All Weld Metal Mechanical Properties

R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)	
500	650	30	+20°C	140
			-196°C	95

Welding Current & Instructions

Welding mode	Ø wire (mm)	Welding parameters		Shielding Gas
		Pulsed arc (A)	(V)	
MIG = +	1.0	120-200	24-28	Ar + 2%CO2 Ar+20%He+0.05% CO2 18-20 l/min
	1.2	140-220	24-28	
	1.6	180-260	24-30	

Ind.10



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