



# TIG 20/10M

Old reference: TIG 316L

## Classification

ISO 14343-A : W 19 12 3 L  
AWS A5.9 : ER316L

Material.N° : 1.4430

## Description & Applications

Low carbon solid rod for TIG welding of stabilised stainless steels (316, 316L...) stabilised or not. Service temperature from -120°C up to +400°C. The TIG process is particularly suited for welding of piping systems, works of fine thinness equal or inferior than 3 mm and for penetration passes.

**Main applications:** Applied in the chemical and petrochemical industries, refineries, food industries...

## Typical Chemical Composition ( % )

C	Si	Mn	Cr	Ni	Mo	Cu	P	S	Fe
0.02	0.45	1.8	18.6	12.4	2.8	0.08	<0.02	<0.01	Rem.

## All Weld Metal Mechanical Properties

R <sub>p0.2</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )	KV ( J )	
410	610	35	+20°C	140
			-196°C	45

## Welding Current & Instructions

Welding mode	Shielding Gas
TIG = -	Ar : 6-12 l/min Back shielding : Argon / Nitrogen : 3-6 l/min

ind.10



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