



H₂ '/A7
 Old reference: TIG 316H

Classification

AWS A5.9 : ER316H

ISO 14343-A : W 19 12 3 H

Description & Applications

Rod for Gas Tungsten Arc Welding, with increased carbon and approx. 5% ferrite designed to weld 17/12/2 (316H) stainless steels as well as stabilized grades used for high temperature service up to 750°C.

Main applications: In petrochemical industries, tanks, heat exchangers, piping systems.

Base materials

Stainless steels for general use:

UNS	Alloy	EN 10088	Mat. N°
S31600	316	X5CrNiMo17 12 2	1.4401
S31609	316H	X6CrNiMoN17 132	1.4919
S31635	316Ti	X10CrNiMoTi18 12	1.4573
S31640	316Cb	X6NiCrMoNb17 12 2	1.4580
J92920	316H		

Typical Chemical Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	P	S	Fe	FN
0.05	0.4	1.7	18.5	11.5	2.1	0.05	0.02	0.01	Rem.	~ 5

All Weld Metal Mechanical Properties

R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)
> 380	> 580	> 30

Welding Current & Instructions

Welding mode	Shielding Gas
TIG = -	Ar : 6-12 l/min Back shielding : Argon or Nitrogen / H ₂ : 3-6 l/min

Ind.10



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