



TIG 20/10MN

Old reference: TIG 316MnN

Classification

ISO 14343-A : W 20 16 3 Mn L Material N° : 1.4455
 AWS A5.9 : ER316LMn

Description & Applications

Rod for Gas Tungsten Arc Welding, designed to weld austenitic stainless like 316L grade. Non-magnetic and free of ferrite on weld deposit. Mainly used for cryogenic applications.

Typical Chemical Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	P	S	N	Fe
0.02	0.5	7.0	20.0	16.0	3.0	0.15	<0.02	<0.01	0.15	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	Shielding Gas
TIG = -	Ar : 6-12 l/min Back shielding : Argon or Nitrogen: 3-6 l/min

Ind.10



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