



SELECTARC UP 316L S.S. SAW Wire

Classification

AWS A5.9 : ER316L
ISO 14343-A : S 19 12 2

Material N° : 1.4430

Characteristics

Solid wire for submerged arc welding of austenitic Cr-Ni-Mo stainless steels and clad plated applied for service temperature from - 120°C up to 400°C.

Applications

Chemical and Petrochemical industries, Refineries, Food industry, Ship building, Pipes and Heat exchangers.

Base Materials

UNS	Alloy	DIN	Material N°	UGINE
S31600	316	X5CrNiMo17-12-2	1.4401	UGINOX 17-10M
S31603	316L	X2CrNiMo17-12-2	1.4404	UGINOX 18-11ML
J92900		G-X5CrNiMo 19 11 2	1.4408	
S31635	316Ti	X5CrNiMo Ti 17-12-2	1.4571	UGINOX 17-11MT
S31635	316Ti	X10CrNiMoTi18-12	1.4573	
S31640	316Cb	X5NiCrMoNb17-12-2	1.4580	

Typical Wire Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	P	S	Fe
0.02	0.50	1.50	19.20	11.65	2.95	0.40	0.025	0.015	base

All Weld Metal Mechanical Properties (Typical)

Conditions	UTS	YS	% Elg	Impact (kJ)	
	R _m (MPa)	R _{p0.2} (MPa)	A ₅	Temp.°C	J
AW	590	380	33	+ 20	70
				- 120	40

Welding Current & Instructions

Process	Ø (mm)	Welding Parameters			Flux
		Current (A)	Voltage (V)	Speed cm/mim	
SAW = +	2.4	300 - 350	25 - 28	45 - 55	UP WP 380 UP WP 380M UP Inox L
	3.2	450 - 500	25 - 28	45 - 55	

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