



# UP 316LMn

## Classification

AWS A5.9 : ER316LMn

ISO 14343-A : S 20 16 3 Mn L

## Description & Applications

Solid wire for submerged arc welding (SAW) of austenitic stainless steel like 316L when weld metal ferrite is needed to be low. Also used to join Type 201,304L, 316L, as well as 3% and 9% Nickel steels. It is used in the cryogenic industry to obtain low impact toughness and high strength. Could be used for overlaying.

**Main applications:** Cryogenic applications...

## Typical Chemical Composition ( % )

C	Si	Mn	Cr	Ni	Mo	Cu	P	S	N	Fe
0.013	0.50	6.8	20.5	16.5	3.1	0.05	0.01	0.007	0.18	Rem.

## All Weld Metal Mechanical Properties\*

R <sub>p0.2</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )	KV ( J )
450	680	30	-196°C

\* With flux UP WP380

## Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Flux
		Current (A)	Voltage	
SAW = +	2.4	275 - 350	28 - 30	WP380 WP380M
	3.2	350 - 450	28 -32	

FT En-SN13-161020

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