

Classifications

AWS A5.9	EN ISO 14343-A	GB/T 5092
ER316L	G (19 12 3 L)	H 03 Cr 19 Ni 12 Mo 2 Si

Characteristics and typical fields of application

- GMAW solid wire of type G 19 12 3 L Si/ ER316L designed for first class welding, good wetting and feeding characteristics as well as reliable corrosion resistance up to +400°C.
- Low temperature service down to -196°C.

Base materials

1.4410 X5CrNiNo17-12-2, 1.4404 X2CrNiMo17-12-2, 1.4435 X2CrNiMo18-14-3, 1.4436 X3CrNiMo17-13-3, 1.4571 X6CrNiMoTi17-12-2, 1.4580 X6CrNiMoNb17-12-2, 1.4583 X10CrNiMoNb18-12, 1.4409 GX2CrNiMoNb19-11-2.
S31653, AISI 316L, 316Ti, 316Cb

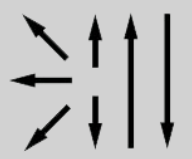
Typical analysis of all-weld metal

C	Si	Mn	P	S	Cr	Ni	Mo			
0.02	0.55	1.70	0.015	0.015	18.4	12.4	2.5			

Mechanical properties of all-weld metal – typical values (min. values)

Condition	Yield strength R _{p0,2}	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact work ISO-V KV J	
	MPa	MPa	%	+20°C	-120°C
AW	430(≥ 350)	570 (≥510)	38 (≥ 30)	100(≥47)	70(≥32)

Operating data

	Polarity:	Shielding gas:	Dimensions (mm)
	DC +	(ISO 14175) M13	0.8 1.0 1.2 1.6

Approvals

CE