MIG / TIG 316LSi

MIG/TIG 316 LSi consumables are used for Mo bearing austenitic Stainless Steels with 1.5-3% Mo. Type 316/316L steels are widely used for their good resistance to pitting, many acids and general corrosion.

CLASSIFICATIONS

AWS	A5.9	ER316LSi
BS EN	12072	19 12 3 L Si
DIN	8556	SG X2CrNiMo 19 12 (1.4430)

CHEMICAL ANALYSIS

% Carbon	0.010	**% Chromium**	18.50
% Manganese	1.400	**% Nickel**	12.80
% Silicon	0.80	**% Molybdenum**	2.600
% Sulphur	0.010	**% Copper**	0.150
% Phosphorus	0.015	**% Ferrite**	6.000

TYPICAL MECHANICAL PROPERTIES ALL WELD METAL

	MIG	TIG
Tensile Strength	570 MPa	605 MPa
0.2% Proof Stress	435 MPa	465 MPa
Elongation on 4d	42%	35%
Impact Energy -130°C	>70J	>100J
Impact Energy -196°C	30-60J	>60J

Microstructure
Austenite with a controlled level of ferrite, normally in the range 2-10FN depending on the application.

PACKING DATA

MIG (DC+ or Pulsed)

Diameter (mm)	Current		Item Number	Pack Mass (Kg)
	Amps	Volts		
0.80	120	19	033-069	15
0.90	160	23	033-070	15
1.00	200	26	033-234	15
1.20	260	26	033-232	15
1.60	280	28	033-073	15

TIG (DC-)

Diameter (mm)	Current		Item Number	Pack Mass (Kg)
	Amps	Volts		
1.60	100	12	030-445	5
2.00	100	12	030-446	5
2.40	100	12	030-447	5
3.20	100	12	030-448	5

Suggested gas for welding : Stainshield, Stainshield Plus (MIG), Argon (TIG)

For more information contact the Afrox Customer Service Centre,
tel: 0860 020202 or e-mail: customer.service@afrox.boc.com
Website: www.afrox.com

AFROX